PEXTO

MACHINES AND TOOLS
FOR
SHEET METAL WORK

CATALOG No. 35A

THE PECK, STOW & WILCOX CO.
Southington, Connecticut, U. S. A.

— ESTABLISHED 1819 —

1819 — 1935

PEXTO

A Mark of Distinction

The Largest Manufacturer of its Kind in the World

MAIN PLANT AND SALES OFFICE

The Peck, Stow & Wilcox Co., Southington, Conn., U. S. A.

The history of the manufacture of tools and machines for fabricating sheet metals parallels with the history of The Peck, Stow & Wilcox Co.

The company was established in 1819 and since that time has stood pre-eminent in its own special field of manufacturing endeavor.

Its products are preferred for their advanced designs, high quality materials, supervised workmanship and long wearing qualities.

The variety in models and sizes of the items herein listed are so extensive that the shop can be equipped complete from this volume.

In addition to this we are prepared to furnish special machines from patterns not represented herein.

[All Inquiries and Orders should be addressed to the firm's Headquarters at Southington, Conn.]

When ordering repair parts, complete serial number of machine for which repairs are required should be specified on order.

SHIPMENTS

Shipments are F. O. B. Cars Factory

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COMPARISON OF GAUGES

ZINC					BROWN & SHARPE							BIRMINGHAM OR STUBBS								U. S. STANDARD								TIN PLATE			DECIMAL EQUIVALENTS of Fractional Inches	
		Weights	Sheet				Brass or Nickel Silver	Weight Lineal Foot in Pounds						Nearest Weight Stock Copper	Weight of Sheets in Pounds							Black Steel Weights	Weight of Sheets in Pounds					COKES AND CHARCOALS — Thickness				
Number Gauge	Inches Thick	Sq. Ft. Lbs.	36"x 84"	48"x 96"	Number Gauge	Inches Thick	Sq. Ft.	14" wide	24" wide	10" wide	Aluminum Weight Sq. Ft.	Number Gauge	Inches Thick	Sq. Ft.	30"x 96"	36"x 96"	36"x 120"	48"x 96"	48"x 120"	Number Gauge	Inches Thick	Sq. Ft. Lbs.	24"x 96"	30"x 96"	36"x 96"	36"x 120"	48"x 144"	Inches	Gauge	Base Weight		
25	.250	9.40			2	.257	11.027	12.86	22.05	9.19	3.588	3	.259	12 lb.				384.	480	3	.250	10									.250	1/4
					3	229	9.819				3.195	5	220	10 lb.				320	400.	5	219	8.75									.2187	7/32
					4	.204	8.745	10.23	17.50	8.18	2.845	6	203	9 lb.				288	360	6	203	8.125									.2331	13/64
					5	.182	7.765				2.534	7	180	8 lb.				256	320.	7	187	7.50									1875	3/16
					6	.162	6.935	8.09	13.87	5.78	2.256	8	165							8	172	6.88									1718	11/64
					7	.144	6.175				2.009	9	148	7 lb.						9	.156	6.25									1562	5/32
												10	134	6 lb.				192	240.	10	140	5.625									1406	9/64
					8	.128	5.499	6.42	11.00	4.58	1.798	11	.120							11	125	5.									125	1/8
					9	.114	4.898				1.594																					
[illegible]	[illegible]	[illegible]			1.	.102	4.361	5.08	8.72	3.63	1.418	12	109	5 lb.				160.	200.	12	109	4.375	70.	87.5	105.	131.25	210.				1093	7/64
[illegible]	[illegible]	[illegible]			11	.091	3.884				1.264	13	095	4 lb.				128.	160.	13	094	3.75									.0937	3/32
	.08	3.0[illegible]			12	081	3.457	4.03	6.91	2.88	1.126	14	083							14	078	3.125	50	62.5	75	93.75	150.				0781	5/64
	.07	[illegible]			13	072	3.08				1.002	15	072							15	.070	2.81										
[illegible]	060	[illegible]25			14	064	2.743	3.20	5.48	2.28	.892	16	065	3 lb.		72.	90			16	063	2.5	40.	50.	60	75	120.				.0625	1/16
18	.055	[illegible]			15	057	2.442				.795	17	.058	2¼ lb.						17	.056	2.25										
17	.050	1.87			16	051	2.175	2.54	4.34	1.81	.708	18	049							18	050	2.00	32.	40.	48.							
16	.045	[illegible]			17	015	1.937				.630	19	042	2 lb.		48.				19	044	1.75									.0468	3/64
15	040	[illegible]			18	040	1.725	2.01	3.45	1.44	561									20	038	1.50	24	30.	36							
14	.036	1.35		43.2	19	035	1.536				.500	20	035							21	034	1.38										
[illegible]	.032	1.20		38.4	20	032	1.367	1.60	2.73	1.19	.445	21	032	24 oz.	30.—	36.—				22	.031	1.25	20.	25.	30						.0312	1/32
	028	1.05		33.6	21	.028	1.218				.396	22	028	22 oz.	27.50	33.—				23	028	1.13						.028	6X	240		
	24	.90		28.8	22	025	1.085	1.26	2.17	.90	.353	23	.025	18 oz.	22.50	27.—				24	025	1.00	16	20.	24.							
					23	.023	.966				.314	24	.022	16 oz.	20.—	24.—				25	022	88						.022	4X	195		
[illegible]	[illegible]	.75	15.8	24.-	24	.020	.860	1.00	1.72	.72	.280	25	.020	14 oz.	17.50	21.—				26	019	75	12	15.	18.			019	3X	175		
[illegible]	[illegible]	.67	14.1	21.5	25	.018	.766				.250	26	018	12 oz.	15.—					27	017	69						.017	2X	155		
		60	12.6		26	.016	.682	.80	1.37	.57	.222	27	016							28	016	63	10.	12.5	15.			.016	1X	135	.0156	1/64
[illegible]	[illegible]	52	10.9		27	.014	.608				.197	28	.014	10 oz.						29	014	56										
					28	.013	.541	.63	1.08	.45	.176	29	.013							30	013	50	8.	10.	12.			.013	IC	107		
6	[illegible]	[illegible]	9.5		29	.011	.482				.157	30	.012	8 oz.						31	011	44						.011		90		
5	[illegible]	.37	8.2		30	.010	.429	.50	.86	.36	.140	31	.010							32	010	41						.010		85		
					31	.009	.382				.124	32	009	6 oz.						33	009	34						.009		75		
4	.008	[illegible]	6.3		32	.008	.340	.40		.28	.111	33	.008							34	008	31						.008		70		
					33	.007	.303				.098	34	.007							36	.007	.28						.007		65		
3	.006	.22	4.6		34	.006	.269	.31		.22	.088	35	.006							38	.008	.25						.006		55		

APPROXIMATE ONLY

NUMERICAL INDEX WITH CODE WORDS

Stock Number	Catalog Page	Code Word
1	40	Pextoright
L1	100	Pextovirac
2	38	Pextoiron
L2	100	Pextoviloco
L3	100	Pextovisa
L4	100	Pextovisby
L5	100	Pextovlona
6	39	Pextosun
10	38	Pextochick
11	40	Pextochamp
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13C	105	Pextogood
15	38	Pextokory
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23C	105	Pextoroof
XC36	11	Pextoyore
XC42	11	Pexeoyork
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101	110	Pextotrab
0101	110	Pextotrang
107	110	Pextotrass
0107	110	Pextotrigal
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122	8	Pextosye
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152 Gang Slit'r	25	Pextoplume
153	25	Pextoplum
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157	25	Pextopath
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169	12	Pextofoyle
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454	51	Pextovedus
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470	61	Pextowick
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479	63	Pextolivar
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486	39	Pextoday
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0532	77	Pextopull
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539	21	Pextolent
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542	76	Pextobus
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0547	77	Pextonash
C0547	77	Pextonab
0548	77	Pextonat
550	78	Pextogem
551	78	Pextojim
556	79	Pextosi[illegible]
561	79	Pextoti[illegible]
562	79	Pext[illegible]
0564	79	Pex[illegible]ad[illegible]
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568	23	P[illegible]l
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569	23	[illegible]towarn
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570	23	Pext[illegible]wand
0570	27	Pextowear
571	23	Pextowheel
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576	76	Pextobeer
581	90	Pextobroe
0581	90	Pextomel
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0585	90	Pexto[illegible]ger
601	90	Pexto[illegible]
0601	90	Pe[illegible]oste[illegible]e
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625	95	Pextogrit	925	104	Pextoblot	1410	61	Pextoopulo
626	83	Pextogirl	927	103	Pextocreas	1411	61	Pextoglok
627	83	Pextoralda	931	103	Pextobeave	1416	56	Pextowhale
628	93	Pextoair	932	103	Pextobevel	1417	56	Pextowart
629	94	Pextoarc	935	103	Pextocop	1418	56	Pextowaul
630	91	Pextogrim	936	103	Pextosquay	1424	60	Pextowen
631	93	Pextomad	938	103	Pextosquir	1425	60	Pextoward
632	93	Pextojest	941	103	Pextohate	1426	60	Pextowoof
633	88	Pextomass	943	103	Pextohat	1427	60	Pextowasp
634	88	Pextosteel	944	103	Pextochat	1428	60	Pextowax
637	98	Pextohubet	947	103	Pextodoll	1430	60	Pextoweb
640	98	Pextomood	949	103	Pextoseam	1442	61	Pextowon
640½	98	Pextomoult	953	104	Pextobotom	1443	61	Pextopatsi
641	98	Pextomoot	956	104	Pextocamel	1444	61	Pextopylos
641½	98	Pextomotio	957	104	Pextonedle	1445	61	Pextopyal
642	98	Pextomope	958	104	Pextotea	1446	61	Pextopurgg
642½	98	Pextomotto	960½	103	Pextomale	1447	61	Pextopunta
644	98	Pextomoore	961	103	Pextomill	1448	61	Pextopukoo
H661½	97	Pextoden	962	103	Pextomole	1449	63	Pextopuna
TL661½	97	Pextodill	964	102	Pextoversa	1469	61	Pextoaneda
MD661½	97	Pextodim	965	103	Pextotub	1470	61	Pextoignon
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675	32	Pextosam	982	102	Pextoplay	1532	77	Pextoavon
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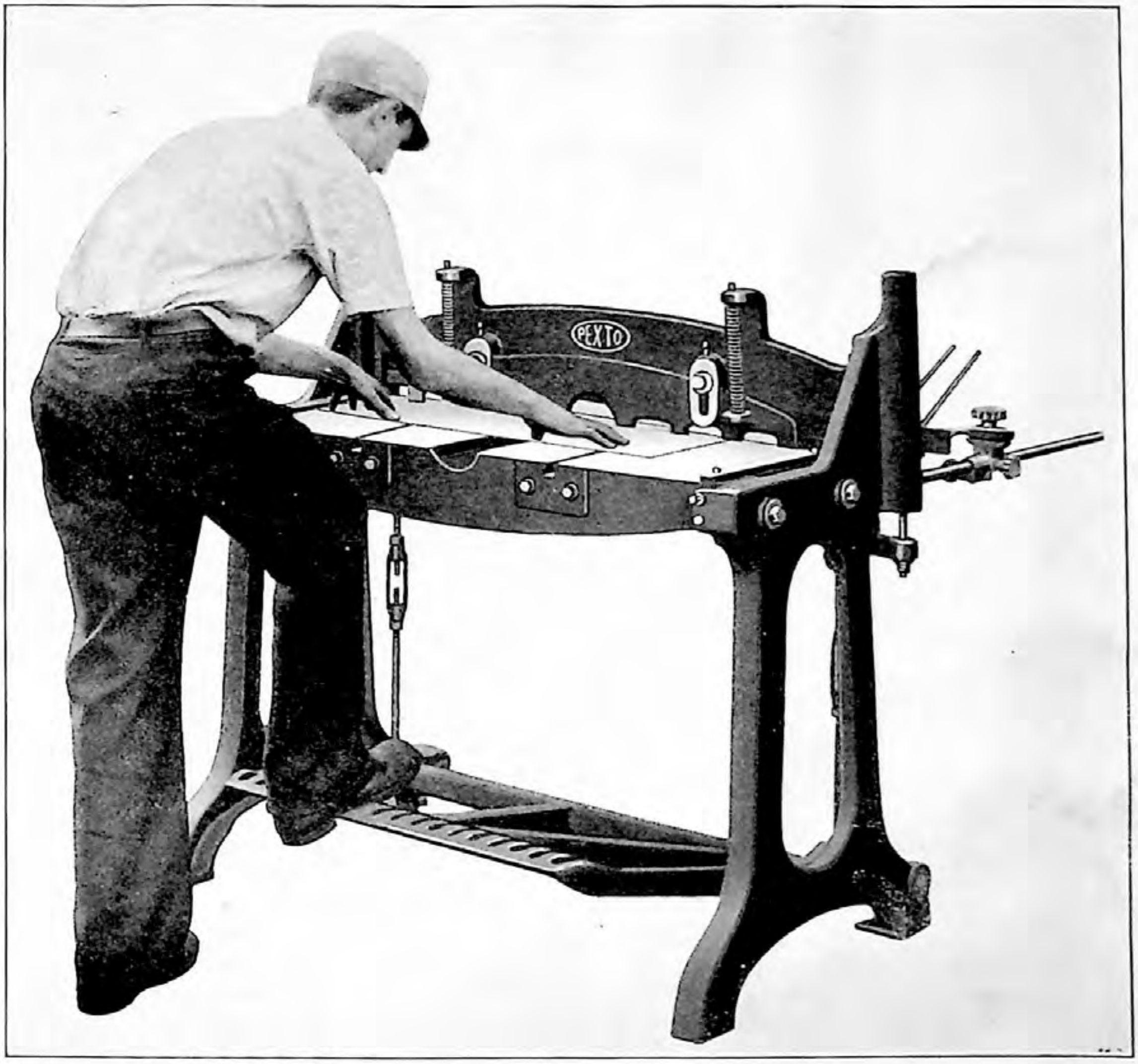
PEXTO

Bulletin B-35

FOOT SQUARING SHEARS



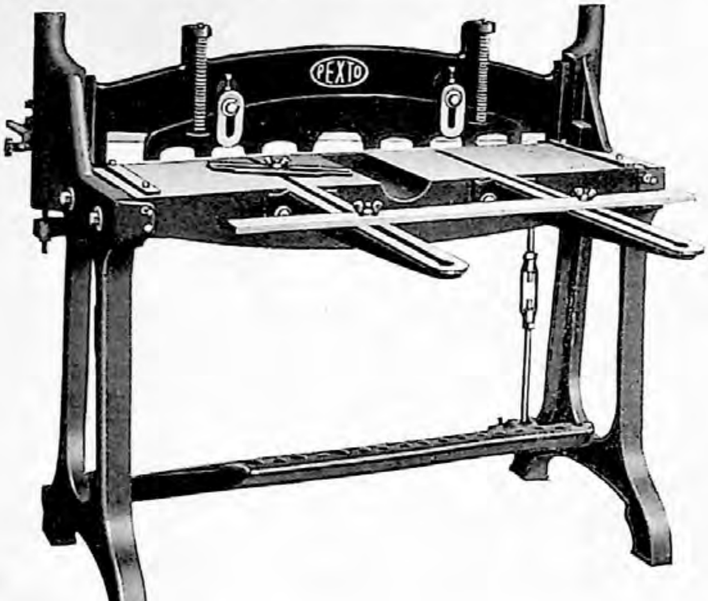
Since the earliest days of the sheet metal working craft, Accuracy, Ease of Operation and Dependability have been first considerations of PEXTO engineers in the manufacture of PEXTO SQUARING SHEARS used for straight and curved cutting.

Steadily developed and improved in design to meet the exacting requirements of present day fabricators of sheet metals and other materials, account for their many unusual design features and performance that has won the unqualified approval of their many users.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

SILVER CITY SQUARING SHEARS



Capacity — No. 18 gauge soft steel and lighter

Number	**122**	**132**	**137**	**142**	**152**
Nominal cutting length ....ins.	22	30	36	42	52
Width of bed ....ins.	12	14	14	14	14
Back gauge range ....up to ins.	16	25	25	25	25
Front gauge range ....up to ins.	23	37	37	37	37
Floor space F to B, R to L without front and back brackets ......ins.	22x34	30x42	30x48	30x53	30x63
Floor space F to B, R to L, with front and back brackets ....ins.	52x34	72x42	72x48	72x53	72x63
Height overall ....ins.	42	44	44	44	49
Shipped on skids, weight approx. lbs.	375	540	650	785	1000

NOTE:—No. 122 has tension springs which are not encased. All other numbers are fitted with compression springs fully enclosed. No. 122 furnished with short front arms. Other numbers are furnished with long front arms. Nos. 137, 142, 152 are regularly equipped with spring-actuated hold-down attachment and which also serves as a finger guard. Nos. 122 and 132 do not have hold-down attachment. For school use finger guard should be specified and which will be applied at no extra cost. No. 142 and No. 152 employ an extension steel treadle. Other numbers have cast treadle. Complete bed and rear gauge equipment furnished with all sizes. See page 13.

A most valuable contribution is to be found in the fully-enclosed compression springs adjustable for varying pressure. In case of spring breakage possible injury to operator is avoided. Not like in older patterns do these springs stretch when the treadle is depressed. Instead they compress making for easier operation. In case of spring breakage the machine will continue to function. With the adoption of this new type of spring of proper proportions and temper interrupted production attendant upon spring breakages is eliminated.

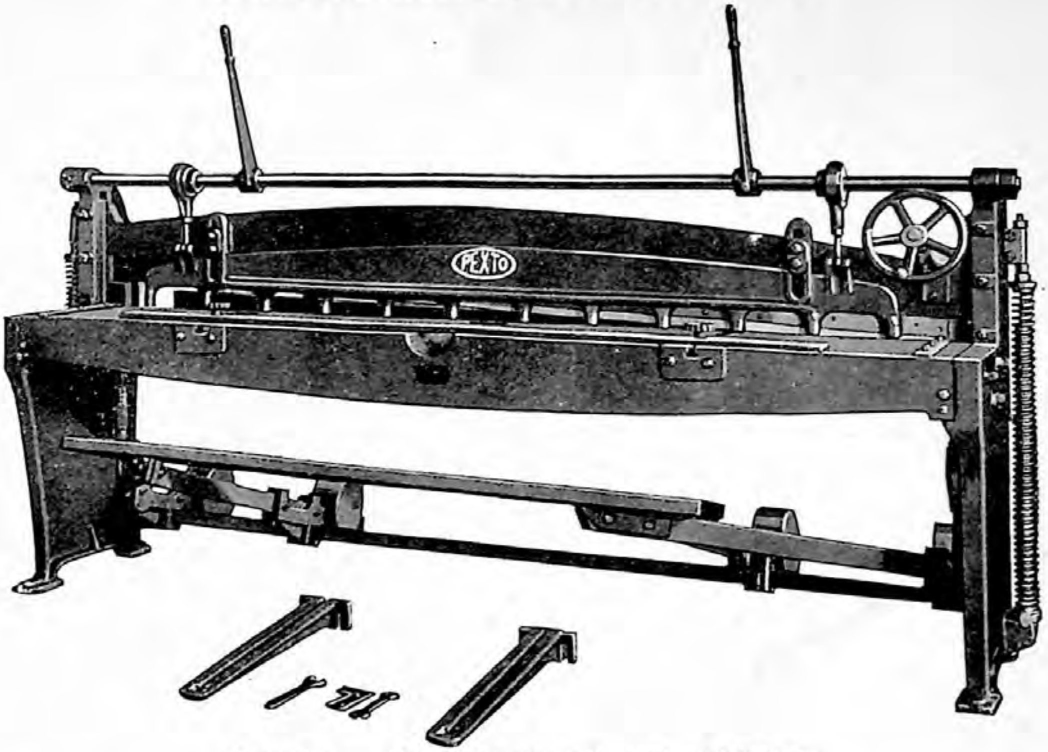
Originality is again claimed in the new and practical precision rear gauge illustration on page 13.

The upper knife bar is fitted with truss rod for maintaining alignment of knives and for rigidity, necessity of placing shims in back of knives when properly ground is thereby eliminated entirely.

The treadle connecting rods are extra heavy to avoid against frequent breakage.

Better grade of materials plus great care in manufacture provide the strength and endurance for which Pexto Squaring Shears are noted.

LONG-LENGTH SQUARING SHEARS



Capacity — No. 18 gauge soft steel and lighter

Number	162	172	YB-96
Nominal cutting length ins.	62	72	96
Width of bed ins.	14	14	16
Back gauge range up to ins.	25	25	18
Front gauge range up to ins.	38	38	40
Floor space F to B, R to L without front and back brackets ins.	46x79	46x89	68x114
Floor space F to B, R to L with front and back brackets ins.	67x79	67x89	86x114
Height overall ins.	68	68	70
Shipped on skids weight approx. lbs.	1600	1800	3050

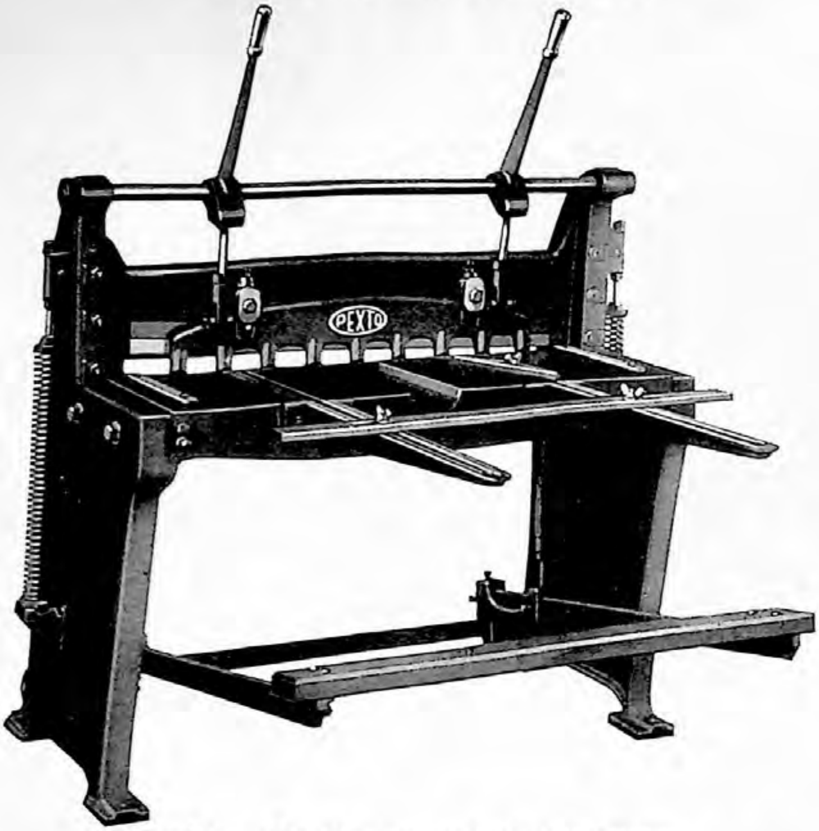
NOTE:—Furnished regularly with hand-operated hold-down attachment, one pair bed extension arms and complete bed and rear gauge equipment. For rear gauge construction see page 13. Hand wheel for operating rear gauge from front of machine as illustrated above is special and only applied when specified at an extra charge.

The design, workmanship and performance of PEXTO Long-Length Squaring Shears leave little to be desired. The long compression springs for raising the upper knife bar provides ease of operation and long life of springs. In this series of Long-Length Foot Squaring Shears counterbalance weights for returning the gate or upper knife bar are included as necessary on the larger size No. YB-96 only. The long compression springs are of proportions and temper to require from them the function of operating the upper knife bar downward. Because counterbalance weights and not high tension springs are depended upon to assist the return of upper knife bar easier operation is the result.

The hold-down attachment is actuated thru conveniently-placed hand levers. This type of hold-down finds its movement by hand and is independent of the movement of the gate which holds the upper cutting knife and may be depended upon as positive. They also employ a rigid steel extension treadle.

The upper knife bar is fitted with truss rod for maintaining alignment of knives and for rigidity, necessity of placing shims in back of knives when properly ground is thereby eliminated entirely.

HEAVY SQUARING SHEARS



Capacity — No. 16 gauge soft steel and lighter

Number		0236	0242	0252
Nominal cutting length	ins.	36	42	52
Width of bed	ins.	14	14	14
Back gauge range	up to ins.	25	25	25
Front gauge range	up to ins.	38	38	38
Floor space F to B, R to L without front and back brackets	ins.	45x52	45x58	45x68
Floor space F to B, R to L with front and back brackets	ins.	77x52	77x58	77x68
Height overall	ins.	64	64	64
Shipped on skids	weight approx. lbs.	1080	1180	1450

NOTE:—Furnished with hand hold-down attachment, one pair bed extension arms and complete bed and rear gauge equipment. See page 13.

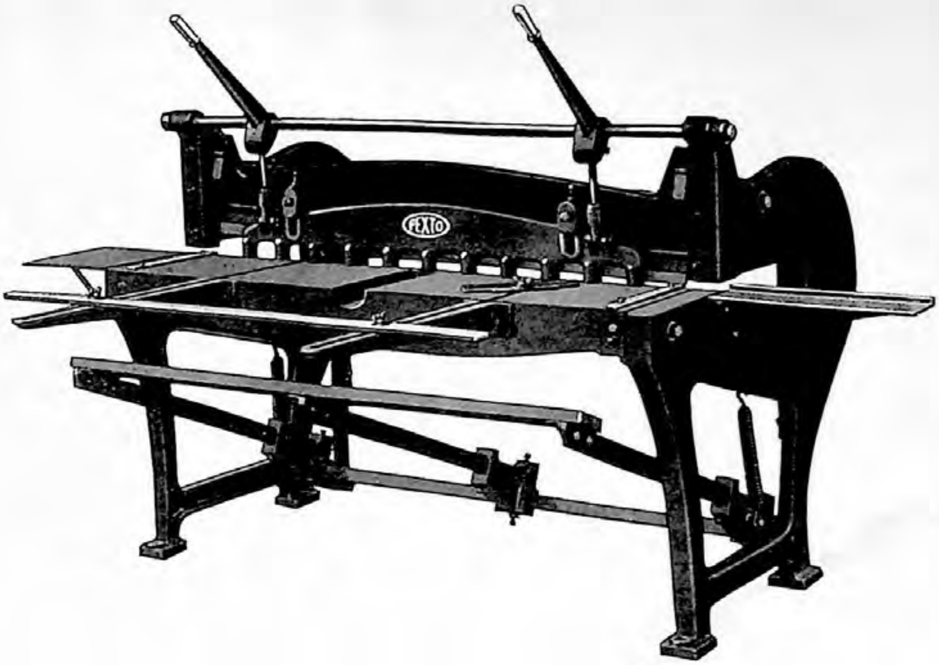
No. 16 Gauge is as heavy as we recommend cutting with a Foot Power Squaring Shears. Iron of heavier gauges should be cut with a Squaring Shears arranged for power drive. These heavy patterns can be depended upon to cut up to their full rated capacity. The use of Power Shears is suggested for continuous cutting of No. 16 gauge. These patterns are preferable over lighter Foot Shears for continuous cutting of No. 18 gauge.

The effort required for operation is decreased through application of long compression springs.

Solid legs, a well-proportioned gate that holds the upper cutting blade and a steel extension treadle are features which make them desirable for the shop where a heavy Foot Power Squaring Shears is used. An easy-working back gauge is furnished as regular equipment but at extra cost we can furnish a parallel screw gauge. The hold-down attachment is positive and moved by hand and is independent of the movement of gate that holds the upper knife.

The upper knife bar is fitted with truss rod for rigidity and which provides an adjustment for maintaining alignment of knives, necessity of placing shims in back of knives when properly ground is thereby eliminated entirely.

GAP SQUARING SHEARS



Capacity — No. 16 gauge soft steel and lighter

Number	XC36	XC42	XC52
Nominal cutting length.....ins.	36	42	52
Depth gap in housings.....ins.	18	18	18
Width of bed.....ins.	14	14	14
Back gauge range.....up to ins.	25	25	25
Front gauge range.....up to ins.	38	38	38
Floor space F to B, R to L without front and back brackets.....ins.	59x45	59x51	59x61
Floor space F to B, R to L with front and back brackets.....ins.	77x45	77x51	77x61
Height overall.....ins.	64	64	64
Shipped on skids.....weight approx. lbs.	1500	1650	1750

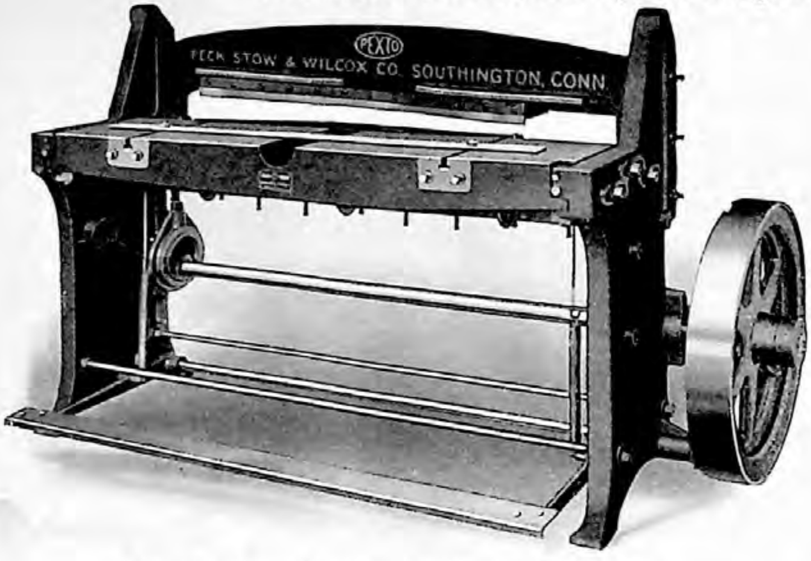
NOTE:—Furnished with side shelf, slitting gauge, one pair bed extension arms and complete gauge equipment. See page 13.

These new patterns embody every improvement for a well-balanced, easy-operating shears. Housings have a gap of 18 inches for permitting the slitting of long sheets from ½ inch wide up to the full depth of the gap in housings. The slitting gauge fitted to right end housing facilitates the slitting of sheets of longer length than the cutting blades. The first cut made, the slitting gauge secures proper alignment of the successive cuts. The lever hold-down presses the sheet with security for insuring an accurate and clean cut. They employ a steel extension treadle. Used as a regular squaring shears, they will cross-cut sheets at any point desired and of full width, according to the length of shears used.

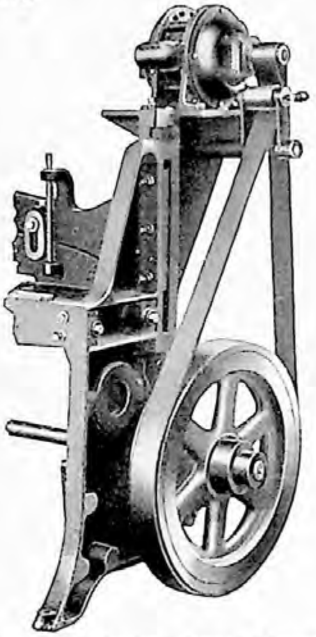
Takes the place of a long-length shears where floor space is limited and for economy. A shears that offers the best to be had from a view point of utility, durability and economy. The upper knife bar is fitted with truss rod for maintaining alignment of knives and for rigidity, necessity of placing shims in back of knives when properly ground is thereby eliminated entirely.

CURVED BLADE SHEARS

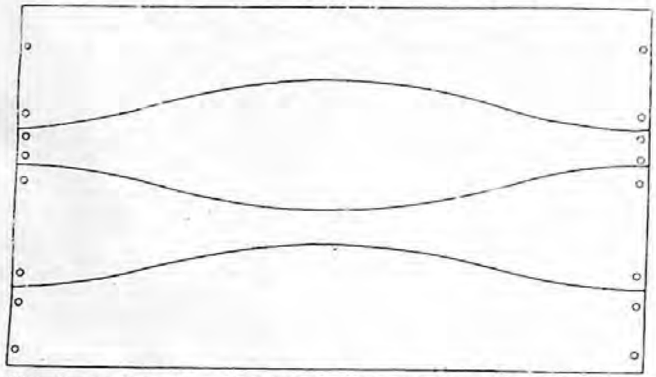
For Elbow Sections and Special Irregular Cutting



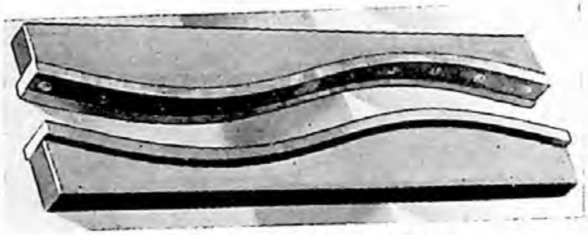
No. P169 — Curved Shears — Belt Drive



Arranged Belted Motor Drive



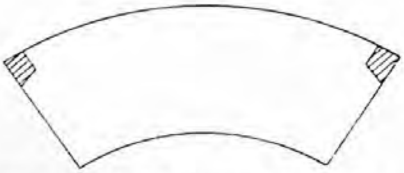
Showing sections of a four pieced elbow cut from the squared sheet. Also adapted for irregular cuts notching and straight cutting when special knives and blocks are applied.



Curved Knife and Blocks
Furnished with pin gauges regularly.

POWER CURVED BLADE SHEARS	No.	P168	P169	P170
Capacity soft steel, maximum	gauge	20	20	20
For curved blades up to overall length	ins.	30	42	52
Will cut sections 90 degree 4 pc. Elbows up to dia.,	ins.	9	12	16
Will cut sections 90 degree 3 pc. Elbows up to dia.,	ins.	7	10	12
Will cut sections 45 degree 2 pc. Elbows up to dia.,	ins.	7	10	12
Size flywheel	ins.	25x4	25x4	25x4
Weight flywheel	lbs.	260	260	260
Speed of flywheel or strokes per minute		75	75	75
Motor requirements	h.p.	1	1½	2
" " flat belt motor drive	r.p.m.	900	900	900
" " v-belt motor drive, geared head motor	"	600	600	600
Shipping weight on skids	approx. lbs.	1185	1400	1680

FOOT OPERATED CURVED BLADE SHEARS	No.	168	169
Capacity soft steel, maximum	gauge	22	22
Will cut sections—see above			
Shipping weight on skids	approx. lbs.	670	840



With special knives adapted for a variety of curved cutting.

NOTE:—Furnished with one pair bed extension arms and bed gauges. Back gauge equipment is not included with curved shears. Power shears are fitted with Pexto square pin safety clutch.

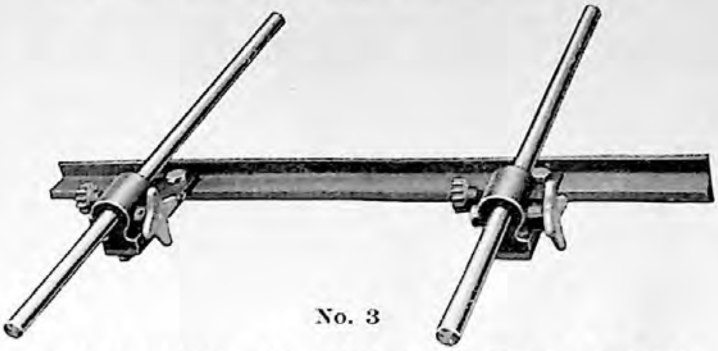
Pexto Curved Knives are mechanically correct for cutting curves absolutely true. Both upper and lower knives are properly hardened and fitted to cast iron blocks.

The upper knife and block is fastened directly to the gate. Lower knife and block is mounted on a holder. Both upper and lower knives are adjustable in and out. The method used for holding lower knife eliminates an excessive number of set screws making vertical knife adjustments comparatively easy and simple.

Can also furnish straight knives and blocks of maximum overall length as specified above for use as regular squaring shear.

Pexto curved blades are machine ground using precision cams and followers.

SQUARING SHEAR BACK GAUGES

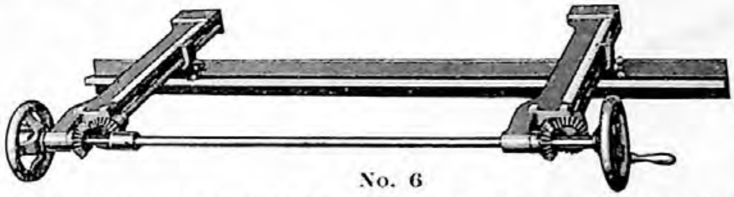


No. 3

STANDARD PRECISION SUPER GAUGE

Regular equipment as included with all numbers of Foot Squaring Shears excepting No. YB-96. Adjustments are made thru rack and pinion and large hand knobs. The small hand nuts lock the adjustments securely. The gauge holders, to which the steel gauge bar is attached, move along the round steel gauge supporting rods freely and without binding.

A scale on top of steel gauge supporting rods and indicator on gauge holders provide for quick and accurate setting of the gauge bar.



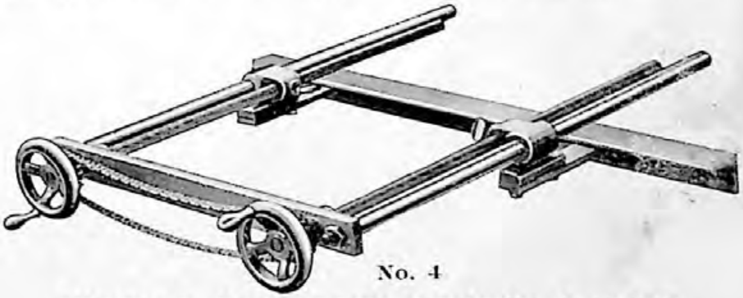
No. 6

STANDARD PRECISION PARALLEL SCREW GAUGE

Regular equipment as included with Foot Squaring Shears No. YB-96.

Squaring Shears No. YB-96, owing to their long length, employ as standard equipment a parallel screw back gauge. The features are found in the gauge bar made of steel for accuracy and serviceability. Back lash in the gauge bar, should screws become worn after continuous use, is guarded against thru a locking device which serves another purpose of locking gauge after settings have been made. Provided with graduated steel scales on each bracket in addition to indicators, gauge settings are made quickly and conveniently. Indicators are adjustable for always maintaining accurate alignment. Through means of long screws and bevel gears, turning hand wheel on either bracket, the gauge bar moves parallel. By disconnecting couplings of transverse shaft, bevel setting of gauge bar can be obtained.

This Gauge can also be applied to Shears Nos. 162 and 172 at nominal extra charge.



No. 4

SPECIAL PARALLEL SCREW GAUGE

This illustration offers a Parallel Screw Gauge that can be furnished at extra cost for Foot Shears of all numbers excepting Long-Length Squaring Shears Nos. 162, 172 and YB-96 which are furnished with their own style of Parallel Screw Gauge. The gauge illustrated will also fit Light Power Squaring Shears.

With this gauge the steel gauge bar moves parallel thru turning hand wheels on either bracket. The movement is thru long screws and chain and sprockets.

POWER SQUARING SHEARS CHART

For more complete information, specifications and illustrations write for Power Squaring Shears Bulletin. The following chart is offered to point out the extent of the PEXTO POWER SQUARING SHEAR line.

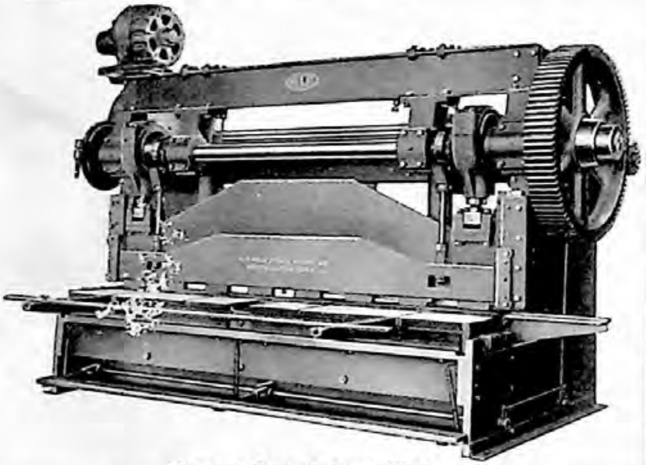
UNDERDRIVEN PATTERN — Cast Iron

Capacity Gauge No.	Underdriven Pattern Stock No.	Cutting Length Inches	Weight Lbs.
16	**U36**	36	1485
16	**U42**	42	1635
16	**U52**	52	1800
16	Heavy **U136**	36	1750
16	" **U142**	42	1900
16	" **U152**	52	2100
16	**U162**	62	2400
16	**U172**	72	2800
18	**U196**	96	4200
18	**U1120**	120	5200
18	**U1144**	144	6000
14	**U236**	36	1850
14	**U242**	42	2000
14	**U252**	52	2300
14	**U262**	62	2600
14	**U272**	72	3000

Larger sizes Series No. S236, No. 14 gauge capacity made in Overdriven Pattern only.

OVERDRIVEN PATTERN — Cast Iron

Can be furnished with Deep Gap	Cap'y Gauge No.	ShallowGap Overdriven Pattern Stock No.	Cutting Length Inches	Weight Lbs.
15 or 18 inches	16	**S136**	36	2200
	16	**S142**	42	2400
	16	**S152**	52	2700
	16	**S162**	62	3100
	16	**S172**	72	3500
Not made with deep gap	14	**S236**	36	2700
	14	**S242**	42	2900
	14	**S252**	52	3200
	14	**S262**	62	3700
	14	**SA272**	72	4200
	14	**S296**	96	7200
	14	**S2120**	120	8900
18"	10	**S336**	36	3700
18	10	**S342**	42	4000
18	10	**S352**	52	4500
18	10	**S362**	62	5000
18	10	**SA372**	72	5600
20	10	**S396**	96	9000
20	10	**S3120**	120	11200
20"	3/16"	**S436**	36	6500
20	3/16	**S448**	48	7000
20	3/16	**S462**	62	7600
20	3/16	**S472**	72	8500
18	3/16	**S496**	96	13000
18	3/16	**S4120**	120	16000
18	3/16	**S4144**	144	20000
18 inches	¼"	**S536**	36	8500
	¼	**S548**	48	10000
	¼	**S562**	62	12000
	¼	**S572**	72	14000



Heavy Overdriven Pattern

All of the above numbers can be arranged flat belt, v-belt or geared motor drives.

OVERDRIVEN PATTERN
Combining Cast Iron with Steel

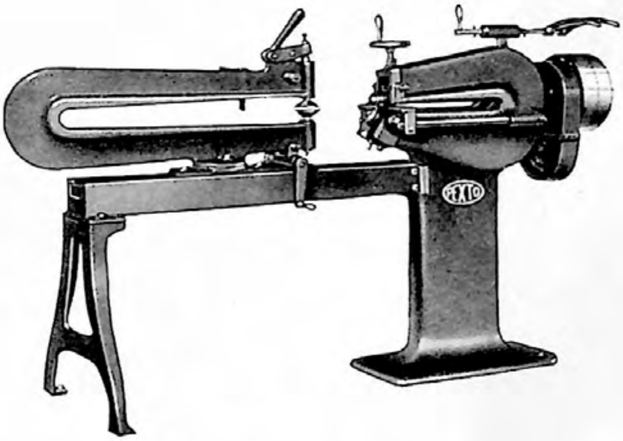
Will cut soft steel thickness ……ins.	⅜	½	5/16	7/16	¼	⅜	5/16	¼
Nominal cutting length ……ins.	**72**	**72**	**96**	**96**	**120**	**120**	**144**	**168**
	38-72	**12-72**	**516-96**	**716-96**	**14-120**	**38-120**	**516-144**	**14-168**
Can be furnished with Deep Gaps								
7" Gap, shipping weight approx. lbs.	18,600	20,900	20,100	23,400	21,100	25,900	28,400	30,900
18" Gap, shipping weight approx. lbs.	19,500	22,000	21,000	24,500	22,000	27,000	29,500	32,000
24" Gap, shipping weight approx. lbs.	20,100	23,000	21,600	25,500	22,600	28,000	30,500	33,000
Length of Shear Knives ……ins.	75	75	99	99	123	123	147	171
Size of Flywheel ……ins.	40x6	45x7	40x6	45x7	40x6	45x7	45x7	45x7
Size of Pulley ……ins.	28x5	36x6	28x5	36x6	28x5	36x6	36x6	36x6
Weight of Flywheel ……lbs.	1100	1400	1100	1400	1100	1400	1400	1400
Speed of Flywheel ……RPM	240	275	240	275	240	275	275	275
Ratio of Gearing ……	7½:1	15:1	7½:1	15:1	7½:1	15:1	15:1	15:1
Motor Required ……HP	10	15	10	15	10	15	15	15
Speed of Motor ……RPM	1200	1200	1200	1200	1200	1200	1200	1200
Back Gauge Range Maximum ……ins.	24	24	24	24	24	24	24	24
Front Gauge Range Maximum ……ins.	52	52	52	52	52	52	52	52

When arranged for individual motor drive flat belt drive or v-belt motor drive is invariably furnished on above shears. Flat belt motor drive is standard.

PEXTO

Bulletin C-35

CIRCLE SHEARS
RING & CIRCLE SHEARS
CIRCLE SHEARS & FLANGERS

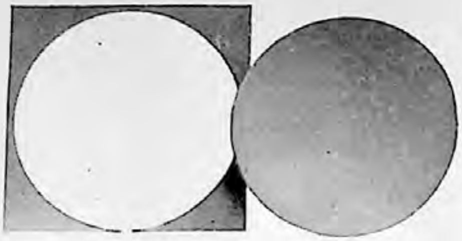


ROTARY SLITTING SHEARS
GANG SLITTING SHEARS
LEVER SCROLL & CUT OFF SHEARS

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

CIRCLE AND RING AND CIRCLE SHEAR USES

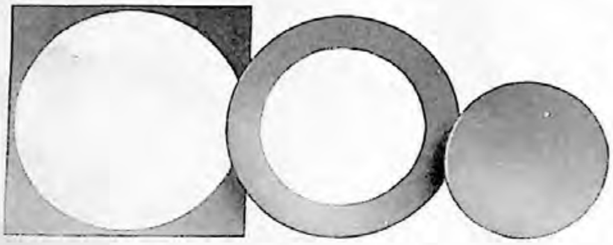


Disc Cutting with the Circle Shears (See Pages 20-23)

The cutting of discs from squared blanks is done on the Circle Shears.

All Circle Shears have parallel shafts fitted with cutters set with the proper clearance that make them practical for outside cutting of discs only.

Adjustments are provided for taking up the wear of the cutters. The construction of the Circle Shears does not permit for the raising of the upper cutter for cutting on the inside of a square sheet without cutting the outer edge.

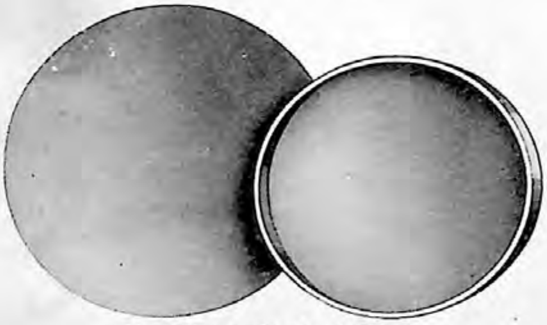


Ring and Disc Cutting with the Ring and Circle Shears (See Pages 17-19)

All Ring and Circle Shears have angular position of the shafts and cutters which permits cutting inside and outside circles. This is possible because the upper cutter is not in a fixed position and can be raised or lowered through means of a crank screw or hand wheel, depending upon the size and capacity of machine selected.

The Ring and Circle Shears is becoming more popular due to its wider range of cutting usefulness over the plain Circle Shears.

Discs can be cut from the inside of a square blank or a disc can be cut from the inside of a disc for making rings or gaskets. In addition discs can be cut from squared blanks as done on the plain Circle Shears.



Combined Circle Cutting and Flanging (See Page 21)

Power Circle Shears with Flanging Attachment are offered in these pages for a large range of diameters of different gauges of steel for performing quickly and accurately in the cutting of discs and for flanging those discs on the same machine with the Flanging Attachment in another operation.

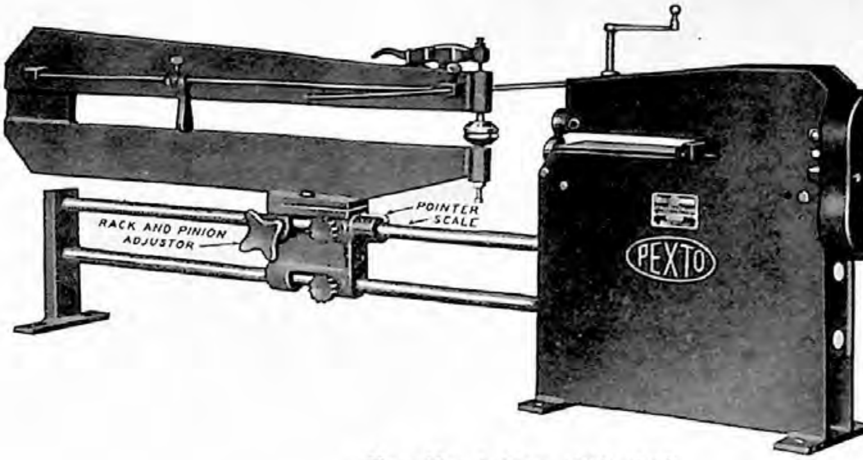
The line, therefore, is divided into three groups of machines—plain disc or circle cutting machines, Ring and Circle Shears and Circle Shears with Flanging Attachment.

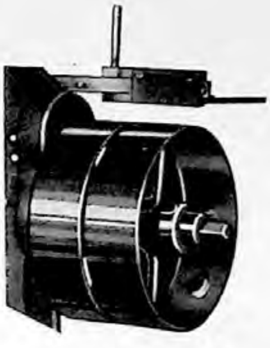
After the minimum and maximum diameters of circles or rings that must be cut have been arrived at, taking the gauge of steel into consideration, select the shears as will best suit the requirements. Circle Shears and Ring and Circle Shears are offered for hand use and for power drive but the Circle Shears with Flanging Attachment are only made for power drive.

These pages are complete with specifications and well illustrated making a selection quite simple.

Our engineers will be only too glad to solve your problem on receipt of complete specifications.

RING AND CIRCLE SHEARS





With T. & L. Pulleys
Nos. 1398 - 1399

For Hand Nos. 398 - 399

Capacity — No. 18 gauge soft steel and lighter

Number—Hand		**398**	**399**
Number—With Tight and Loose Pulleys		**1398**	**1399**
Number—Arranged for Belted Motor Drive		**2398**	**2399**
Will circle from square blanks	ins.	3 to 24	3 to 42½
Depth of Throat in Circle Arm	ins.	17½	30½
Depth of Cuttting Head to Frame	ins.	10	10
Depth of Cutting Head to Gauge	ins.	9⅜	9⅜
Diameter of Cutters	ins.	1¾	1¾
Diameter of Clamping Discs	ins.	2	2
Size of Pulleys	ins.	10x2½	10x2½
Speed of Pulleys	R.P.M.	120	120
Speed of Cutters	feet per minute	55	55
Motor required—"v" belt motor drive	H.P.	½	½
Speed of Motor—"v" belt motor drive, geared head	R.P.M.	300	300
Shipped crated, Hand	approx. lbs.	230	250
Shipped crated, with T. & L. Pulleys	approx. lbs.	260	280

Furnished regularly for bench use. Floor Legs can be fitted at extra cost. When ordered for individual motor drive the above numbers are regularly furnished for "v" belt motor drive. They can also be furnished with direct connected geared head motor attached to drive shaft by means of flexible coupling. Motor required—½ H.P. 125 R.P.M. Geared head.

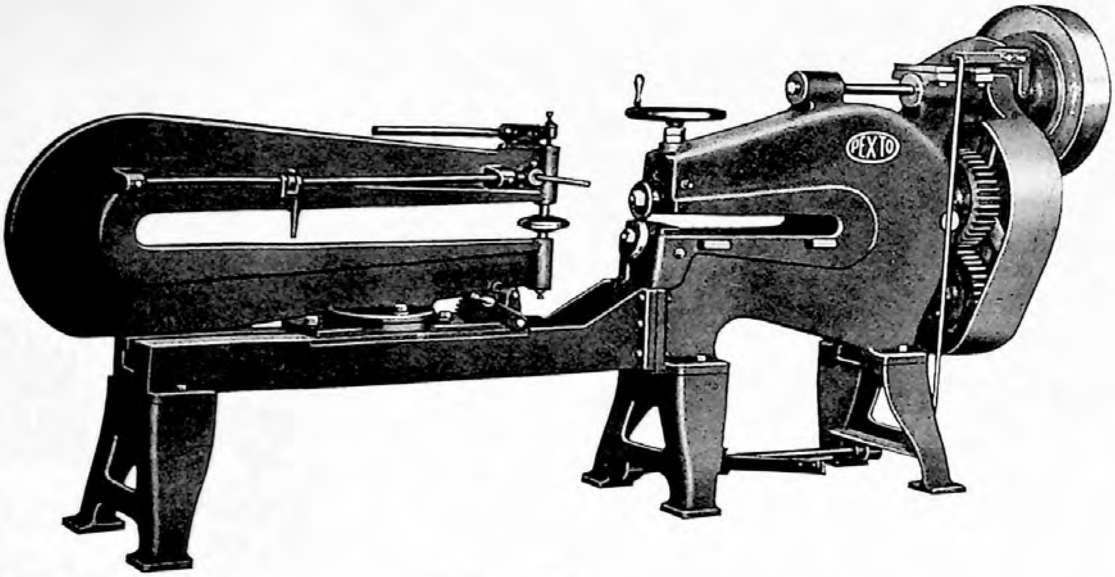
PURPOSE — To cut circles or discs and rings or gaskets as well as circular holes in rectangular blanks as illustrated on page 16. The cutter head is fitted with gauge for slitting and can be utilized for irregular cutting.

OPERATION — Driven from the lower shaft, the blank that is being cut will rotate going from the operator the scrap discharged falling in back of machine. The upper cutter is raised or lowered by means of crank screw provided with lock nut to fix the lowest advisable position of cutters. The eccentric lever for clamping blanks is quick acting, regulated by a set screw and lock nut. Both clamping discs are covered with rubber. The lower clamping disc is fitted with a center point. Lateral adjustment provided on upper cutter arbor for correct cutter clearance.

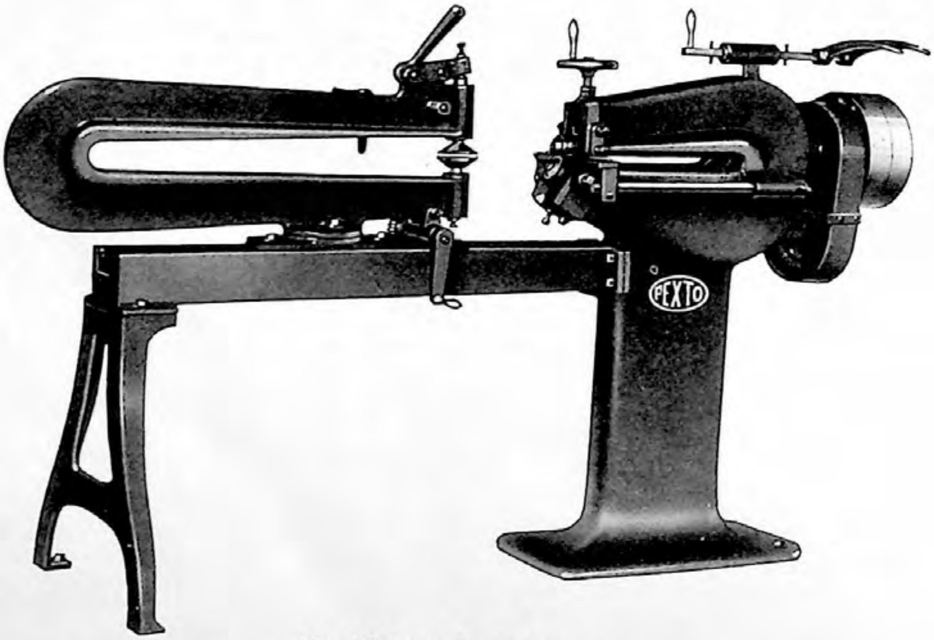
FEATURES — Drive is obtained through spur type connection gears. A universal joint connects the lower cutter spindle with the drive shaft avoiding the resorting to obsolete rough cast tooth bevel gears. Circle Arm is provided with rack and pinion with hand knob for rapid adjusting. It is locked by means of hand knobs with screws. An indicator and a direct-reading scale is provided on upper support rod. The cutting head is a heavy box section of welded steel construction. Designed for rigidity and strength throughout.

POWER RING AND CIRCLE SHEARS

For Description and Specifications see Page 19



Nos. 537-538



No. 535 not Back Geared

No. 536 Back Geared

NOTE—Gearing on Back Geared Machines enclosed in Gear Guards.

POWER RING AND CIRCLE SHEARS

For Illustration see Page 18

These machines are intended for cutting discs from square blanks and also for cutting rings or gaskets. Upper cutter is not fixed but can be raised or lowered thru a hand wheel permitting for cutting on the inside of a sheet without cutting the outer edge. It is provided with lateral adjustment for proper cutting clearance. Using universal joints, no noisy cast tooth bevel gears are employed in the construction for driving of the cutters. All gears are machine cut for smooth running and durability.

The customer has the option of specifying the clamping discs to be fitted with a hand wheel or eccentric lever without extra charge and the method for clamping discs as preferred by the customer should be specified. Otherwise eccentric lever will be furnished.

The lower clamping disc is fitted with center point.

The circle arm moves easily thru rack and pinion and hand lever.

These are stocky machines with the stuff built into them to stand up under daily production. No improvement has been overlooked for making them complete and easy to operate.

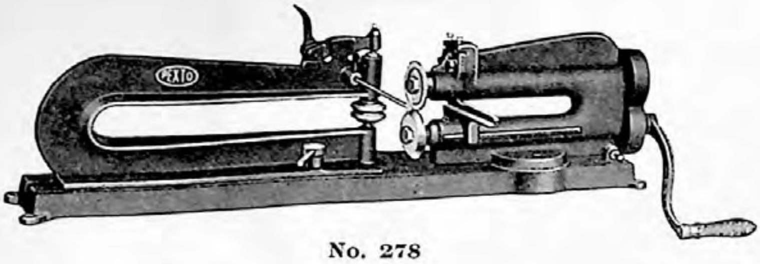
Alemite equipped thruout — Grease gun furnished.

Number		**535**	**536**	**537**	**538**
Capacity Soft Steel	Gauge No.	16	12	3/16	3/16
Diameter of Cutters	ins.	2¼	3¼	5	5
Depth Cutting Head	ins.	18¼	19	25	37
Depth Circle Arm	ins.	35	42	48	48
Will Circle from Square Blanks	ins.	5–48	6–60	12–60	12–60
Size of Pulleys	ins.	12x2½	12x3	24x4½	24x4½
Speed of Pulleys	R.P.M.	95	270	250	250
Ratio of Gearing			4:1	5:1	5:1
Horse Power Required	H.P.	¾	1½	3	3
Speed of Motor	R.P.M.	900	1200	1200	1200
Shipped on Skids	Approx. lbs.	1200	1750	3800	4550

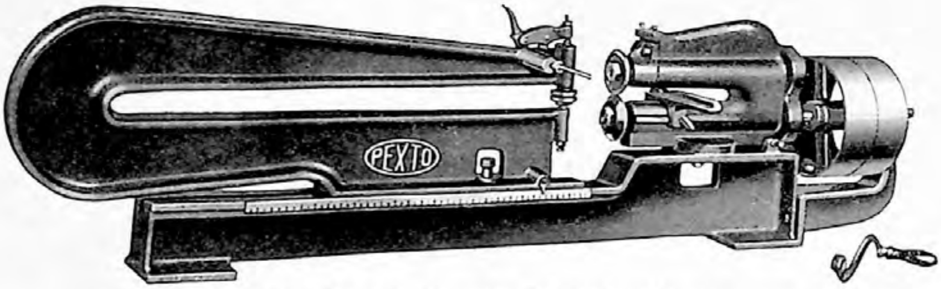
NOTE—Furnished Regularly with Tight and Loose Pulleys. Treadle operated Friction Clutch or Attachments for Direct Connected Motor are Extra.

Pexto machines embody the best of materials and where ordinary good care is exercised they will last for time indefinite. Keep all working parts well lubricated and check up adjustments occasionally to insure long life and good satisfaction.

CIRCLE SHEARS



No. 278



No. X280 For Hand — No. 1280 For Power

Number	Hand 278	Hand X280	Power 1280
Capacity — Soft Steel and Lighter .... Gauge No.	22	18	18
Diameter Cutters .... ins.	3 1/16	3 ½	3 ½
Diameter Rubber Covered Clamping Discs .... ins.	2	2 ¾	2 ¾
Depth Cutting Head to Gauge .... ins.	9 ¼	9 ¾	9 ¾
Depth Cutting Head to Frame .... ins.	10 ¼	10 ¼	10 ¼
Depth Circle Arm .... ins.	16 ¼	34 ½	34 ½
Size of Pulleys .... ins.			12x3
Will circle from square blanks .... ins.	2 ¾ to 22	3 to 48	3 to 48
Speed of Cutters .... feet per minute			90
Speed of Pulleys .... R.P.M.			100
Shipped boxed regularly .... weight approx. lbs.	140	400	450

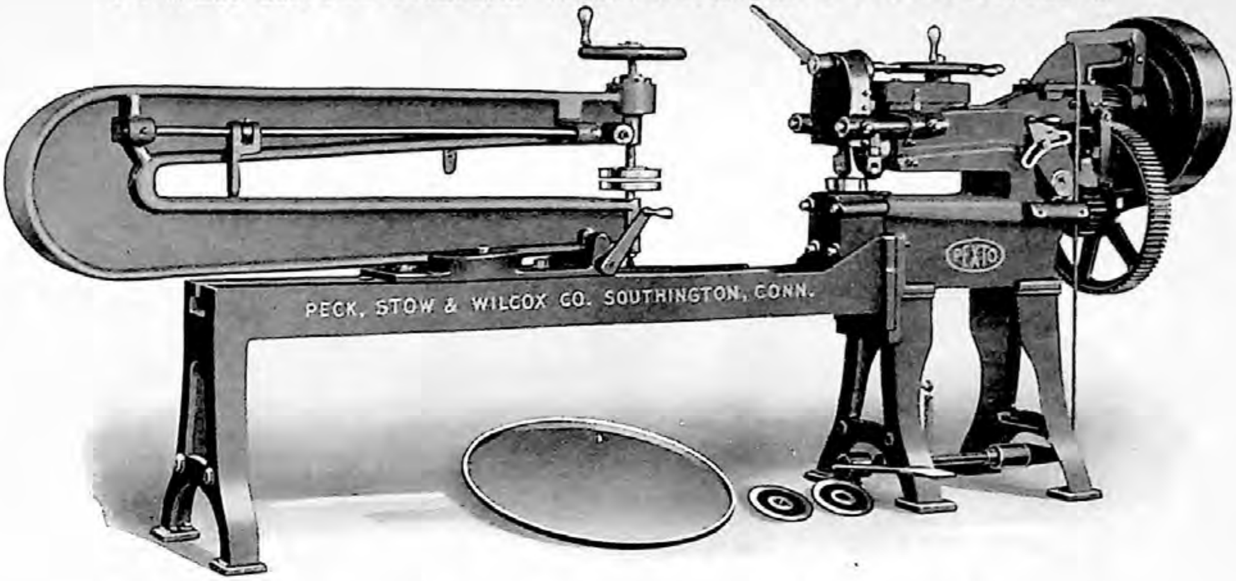
When ordered for Power, Tight or Tight and Loose Pulleys are fitted as may be specified.

PURPOSE — For the cutting of circular blanks. The upper cutter is fixed with adjustments provided for wear. Particularly adapted for brass and copper spinners where many of the same size of blanks are cut.

SPECIFICATIONS — Provided with an eccentric lever for clamping blanks and the clamping discs are rubber covered. In addition the lower disc is fitted with center point.

A scale is provided on the bed for quick and accurate setting of circle arm.

POWER CIRCLE SHEARS WITH FLANGING ATTACHMENT



Can be furnished as a Circle Shears without Flanging Attachment if required.

Number		**539**
Shipped on Skids	weight approx. lbs.	2600
Horse Power Required	approx. H.P.	3—1200 R.P.M.
Will Cut in Thickness or Lighter	gauge	3/16
Will Flange in Thickness or Lighter	gauge No.	10
Depth of Cutting Head to Frame	ins.	16½
Throat of Circle Arm Standard	ins.	38½
Diameter of Cutters	ins.	7
Speed of Cutters	feet per minute	50
Size of Pulleys	ins.	24x4
Speed of Pulleys	R.P.M.	165
Ratio of Gearing		6:1
Will Circle from Square Blank with Std. Circle Arm	ins.	14" Dia. up to 53" Dia.
Will Flange in Diameter	ins.	16" Dia. up to 72" Dia.
Maximum Height of Flange	ins.	1½

Special Circle Arm with 54" Throat can be furnished for Cutting from Square Blank 76 inches at Extra Charge.

Height of Flange which can be Formed depends largely on Thickness of Material. The Lighter Material the less the Height of the Flange which can be Formed. For Capacities see following Table.

Thickness of Soft Steel	Max. Flange	Thickness of Material	Max. Flange
10 Gauge	1½ inch	16 Gauge	1⅛ inch
12 Gauge	1⅜ inch	18 Gauge	1 inch
14 Gauge	1¼ inch	20 Gauge	⅞ inch
		22 Gauge	13/16 inch

GENERAL DESCRIPTION.

In addition to cutting circles this machine will flange discs turning smooth flanges of 90°.

For cutting circles the flanging attachment and hold down are removed and cutters are substituted.

It takes in a large range of diameters of different gauges of iron performing quickly and accurately. Lateral adjustment is provided on upper rocking box for the convenient setting of flanging rolls and cutters.

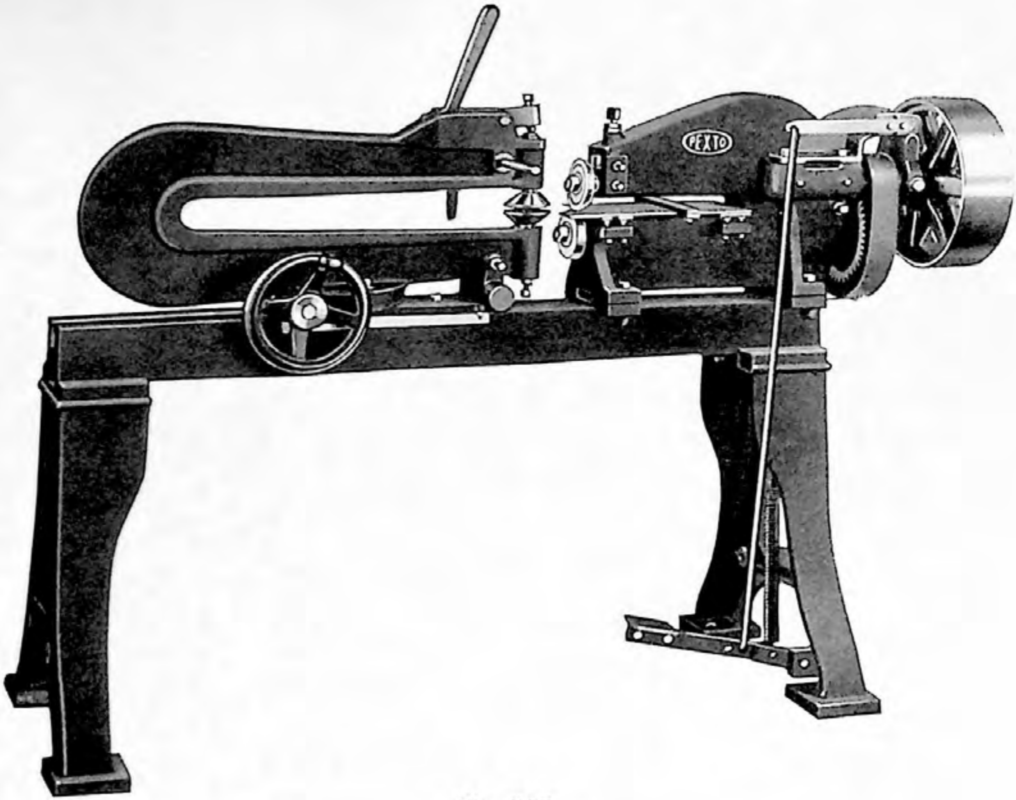
All gears are machine cut.

Shipped with treadle operated Friction Clutch as illustrated regularly which is the best practice. State height of flanges and gauge material to be used.

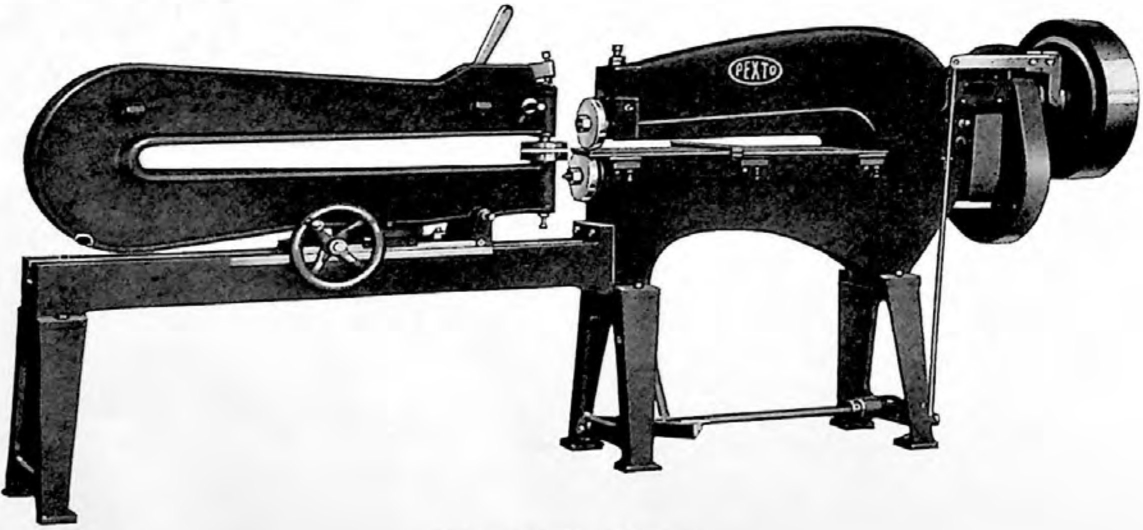
Alemite equipped thruout — Grease gun furnished.

POWER CIRCLE SHEARS

For Description and Specifications see Page 23



No. 565



Nos. 568 to 571 incl.

Gears Enclosed in Gear Guards.

POWER CIRCLE SHEARS

For Illustrations see Page 22

Number		565	568	569
Capacity Soft Steel	Gauge No.	16	⅛	⅛
Diameter Cutters	ins.	4	6	6
Depth Cutting Head	ins.	13	13	20
Depth Circle Arm	ins.	26	26	35
Will Circle from Square Blanks	ins.	6-36	10-36	10-48
Size of Pulleys	ins.	14x3	16x4	16x4
Speed of Pulleys	R.P.M.	210	210	210
Speed of Cutters	feet per minute	63	70	70
Ratio of Gearing		3½:1	4½:1	4½:1
Horse Power Required	H.P.	¾	1½	1½
Speed of Motor	R.P.M.	900	1200	1200
Shipped on Skids regularly	approx. lbs.	850	1150	1400

NOTE—Slitting Table and Gauge in the Cutting Head is Regular Equipment. Treadle Operated Friction Clutch or Attachment for Direct Connected Motor are Extra. Shipped Regularly with Tight and Loose Pulleys.

Number		570	571
Capacity	Gauge	⅛	3/16
Diameter Cutters	ins.	6	7
Depth Cutting Head	ins.	31	16½
Depth Circle Arm	ins.	43	35
Will Circle from Square Blanks	ins.	10–60	12–48
Size of Pulleys	ins.	16x4	24x4
Speed of Pulleys	R.P.M.	210	210
Speed of Cutters	feet per minute	70	65
Ratio of Gearing		4½:1	6:1
Horse Power Required	H.P.	1½	3
Speed of Motor	R.P.M.	1200	1200
Shipped on Skids regularly	approx. lbs.	1900	1950

NOTE—Slitting Table and Gauge in the Cutting Head is Regular Equipment. Treadle Operated Friction Clutch or Attachment for Direct Connected Motor are Extra. Shipped Regularly with Tight and Loose Pulleys.

A producing line that has the quality and workmanship built into each machine to stand up under the test of daily use.

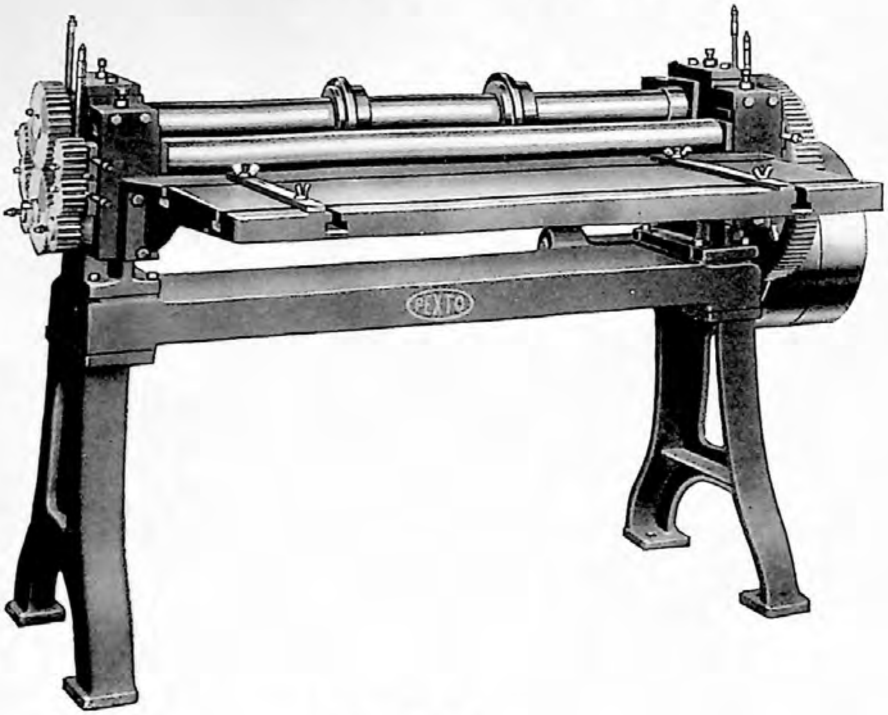
No. 568 has solid frame and base. Nos. 569, 570, 571 have solid frame mounted on floor legs.

Hand wheel or eccentric lever for clamping discs is applied at customer's option without extra charge. Unless eccentric lever is specified we will fit hand wheel on all numbers excepting No. 565 which is regularly furnished with eccentric lever.

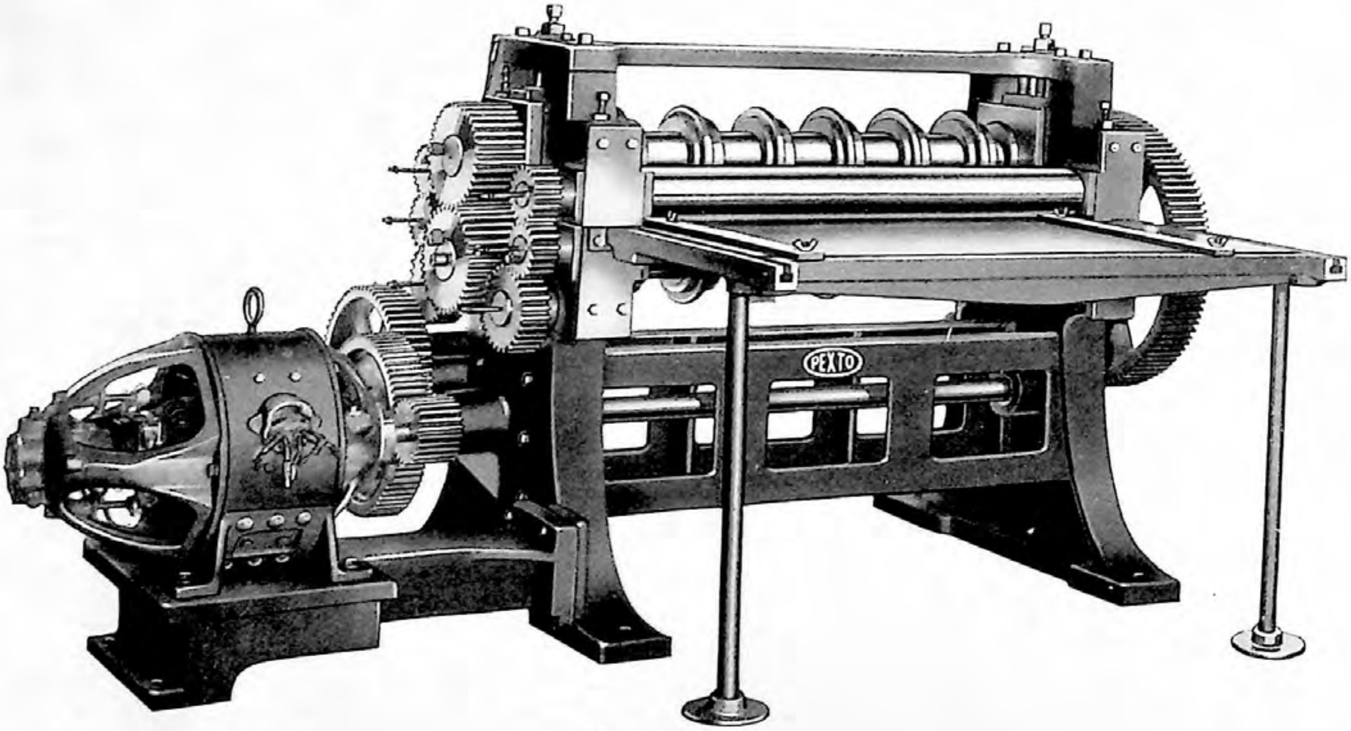
Alemite equipped thruout — Grease gun furnished.

POWER GANG SLITTING SHEARS

For Description and Specifications see Page 25



No. 152 Series



No. 155 Series

Gears are Enclosed in Gear Guards.

POWER GANG SLITTING SHEARS

For Illustrations see Page 24

As now made improved cutter hubs are fitted. Cutter hubs are keyed and clamped to cutter shafts to insure a positive uniform grip all around the shaft making cutters run dead true. No set screws are used.

Provided with feed rolls in front and discharge rolls in rear of machine.

Automatic driven push feed can be furnished at extra cost.

Alemite equipped thruout — Grease gun furnished.

MOTOR DRIVEN CUTTER GRINDING ATTACHMENT

Motor driven cutter grinding attachment can be furnished at extra cost. This attachment is easily applied to rear of machine. The upper and lower cutters can be ground on faces as well as on their circumference without the removal of any parts. Graduation is provided for obtaining the correct cutting angle. A universal motor is included with extension cord and socket.

CAPACITIES FOR SOFT STEEL

Nos. 152 - 153 - 154

16 Gauge Soft Steel	cuts	2
18	cuts	3
20	cuts	4
22	cuts	6
24	cuts	8
26	cuts	10
28	cuts	12

Number		**155**	**156**	**157**	**158**
16 Gauge	cuts	11	10	8	8
18 Gauge	cuts	11	12	10	10

		Series No. 152	**Series No. 155**
Minimum width of strips that can be cut	ins.	2½	3¼

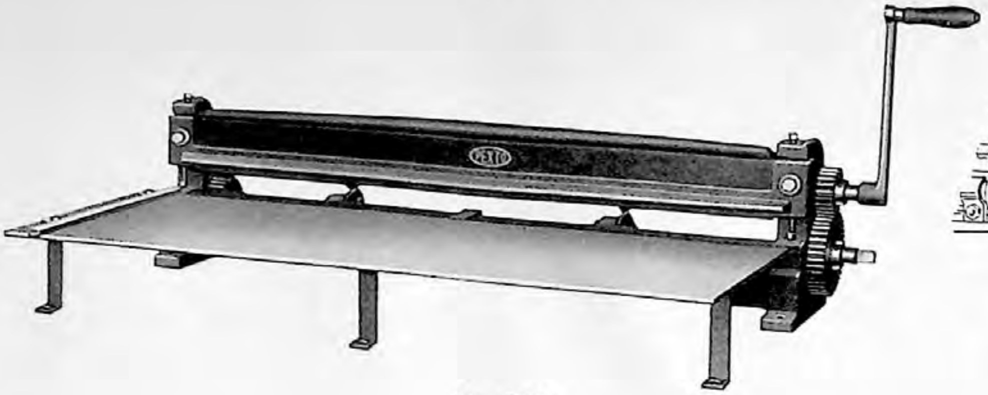
No. 152 Series

Number		**152**	**153**	**154**
Diameter of Cutters	ins.	6 3/16	6 3/16	6 3/16
Diameter of Cutter Shafts	ins.	2 15/16	2 15/16	2 15/16
Maximum Width between Gauges	ins.	32	38	44
Will Trim Sheets in Width up to	ins.	30	36	42
Size of Pulleys	ins.	16x4	16x4	16x4
Speed of Pulleys	R.P.M.	240	240	240
Ratio of Gearing		6:1	6:1	6:1
Speed of Cutters	Feet per minute	60	60	60
Approx. H. P. Required		2	2	3
Speed of Motor	R.P.M.	1200	1200	1200
Height from Floor to Top of Table	ins.	36	36	36
Floor Space F to B—R to L	ins.	42x63	42x69	42x75
Shipped on Skids regularly	weight approx lbs.	1600	1900	2200

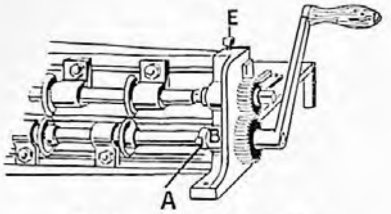
No. 155 Series

Number		**155**	**156**	**157**	**158**
Diameter of Cutters	ins.	9 3/16	9 3/16	9 3/16	9 3/16
Diameter of Cutter Shafts	ins.	4½	4½	4½	4½
Maximum Width between Gauges	ins.	38	44	50	56
Will Trim Sheets in Width up to to	ins	36	42	48	54
Size of Pulley	ins.	28x5	28x5	28x5	28x5
Speed of Pulleys	R.P.M.	380	380	380	380
Ratio of Gearing		20:1	20:1	20:1	20:1
Speed of Cutters	Feet per minute	42	42	42	42
Approx. H. P. Required		7½	7½	10	10
Speed of Motor	R.P.M.	1200	1200	1200	1200
Height from Floor to Top of Table	ins.	34½	34½	34½	34½
Floor Space F to B—R to L	ins.	60x88	60x94	60x100	60x106
Shipped on Skids regularly weight approx. lbs.		5200	6200	7200	8200

GANG SLITTING SHEARS



No. 254



Cutter application of No. 254 Gang Slitter

Number	254 Hand	245 Power
Capacity No. 20 gauge soft steel or equivalent	2 cuts	2 cuts
Capacity No. 22 gauge soft steel or equivalent	2 cuts	2 cuts
Capacity No. 24 gauge soft steel or equivalent	3 cuts	3 cuts
Capacity No. 26 gauge soft steel or equivalent	4 cuts	4 cuts
Capacity No. 28 gauge soft steel or equivalent	5 cuts	5 cuts
Maximum distance between end cutters as shipped regularly ins.	32	36
Maximum distance between end cutters when reversing end cutters and cutter holders ins.	34	
Maximum distance between housings ins.	36	38
Diameter of cutters ins.	3 1/16	
Minimum width of strip that can be cut ins.	2½	1¾
Ratio of Gearing	2:1	5:1
Speed of Cutters R.P.M.		85
Speed of Cutters feet per minute		66
Speed of Drive Shaft R.P.M.		425
Size of Pulleys ins.		12x2¼
Motor requirements		¾ H.P., 1800 R.P.M.
Size of Table ins.	14x34	18¼x40½
Shipped regularly boxed, table crated approx. lbs.	260	500

NOTE:—Furnished regularly with two pairs cutters and adjustable cutter holders. One pair cutters and cutter holders are required for each additional cut desired within the capacity of machine as above ratings. No. 245 regularly furnished with Tight and Loose Pulleys. No. 254 is hand operated.
Floor Legs can be applied at additional charge.

No. 254 is a plain hand Gang Slitter without feed rolls and is the most inexpensive hand machine afforded for multiple cutting.

No. 245 is a Power Gang Slitter fitted with table and gauge and equipped with feed rollers in front and back of cutters for accurate shearing. An inexpensive and highly practical, well-constructed multiple shearing machine where production does not warrant the investment of heavy high-production Gang Slitters as Series 152 and 155 on pages 24 and 25. For the convenient locating of the cutters a 36 inch graduated scale is provided on the upper cutter bar holder for quick adjustment of cutters.

Recommendations will be gladly furnished on receipt of information as to gauge and kind of material, number of cuts and approximate production desired.

ROTARY SLITTING SHEARS

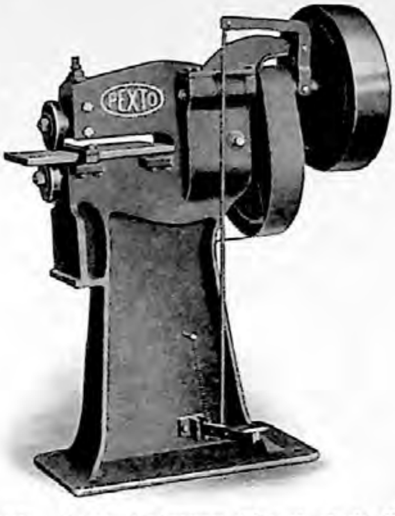
POWER ROTARY SLITTING SHEARS

Number	0568	0569	0570	0571
Will cut up to thickness ......ins.	⅛	⅛	⅛	3/16
Cutting Head, depth ....ins.	13	20	31	16½
Cutting Head, depth to Ga., ins.	11½	18½	29½	14½
Diameter Cutters ....ins.	6	6	6	7
Ratio of Gearing	4½:1	4½:1	4½:1	6:1
Size of Pulleys ....ins.	16x4	16x4	16x4	24x4
Speed of Pulleys ..............R.P.M.	210	210	210	210
Speed of Cutters......ft. per min.	70	70	70	65
Horse Power required ......H.P.	1½	1½	1½	3
Speed of Motor ..................R.P.M.	1200	1200	1200	1200
Shipped on Skids approx. lbs.	800	950	1300	1500

Furnished regularly with Table and Gauge and Tight and Loose Pulleys. Arranged with friction clutch or motor drive are features that cost extra.

No. 0568 has a solid frame and base. All other numbers have a solid frame mounted on floor legs.

Designed for heavy duty with long-wearing parts for continuous use on high production.



No. 0568—With Friction Clutch Belt Drive

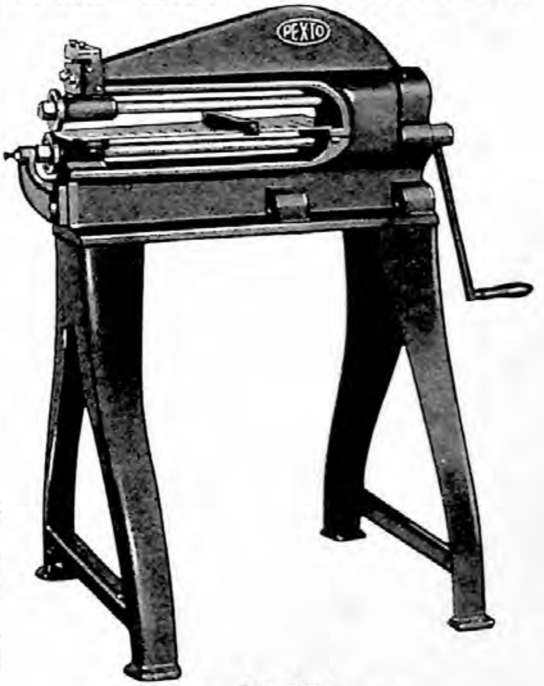
RAPID SLITTING SHEARS

Capacity — No. 16 gauge Soft Steel and lighter

Number	Hand 255	With T&L Pulleys 260
Diameter Cutters ....ins.	3 1/16	3 1/16
Cutting Head depth ....ins.	19	19
Cutting Head depth to Gauge ....ins.	18	18
Size of Table ....ins.	20x8	20x8
Ratio of Gearing	D.A.	4:1
Size of Pulleys ....ins.		14x3
Speed of Pulleys ..............R.P.M.		260
Speed of Cutters ....feet per minute		51
Horse Power required ..............H.P.		¾
Shipped crated ....approx lbs.	330	400

When ordered for power, and friction clutch in place of pulleys is required, specify as No. 0260.

The deep throat permits for slitting sheets 36 inches wide. A desirable substitute for the long-length Squaring Shears where floor space is limited. The table is steel and cutters are reversible having two cutting edges. Crank is adjustable for short or long leverage.



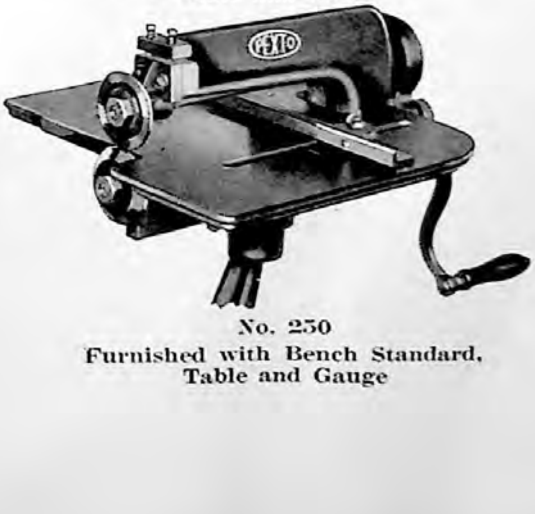
No. 255
Furnished with Floor Legs, Table and Gauge

BENCH ROTARY SHEARS

Capacity — No. 20 gauge Soft Steel and lighter

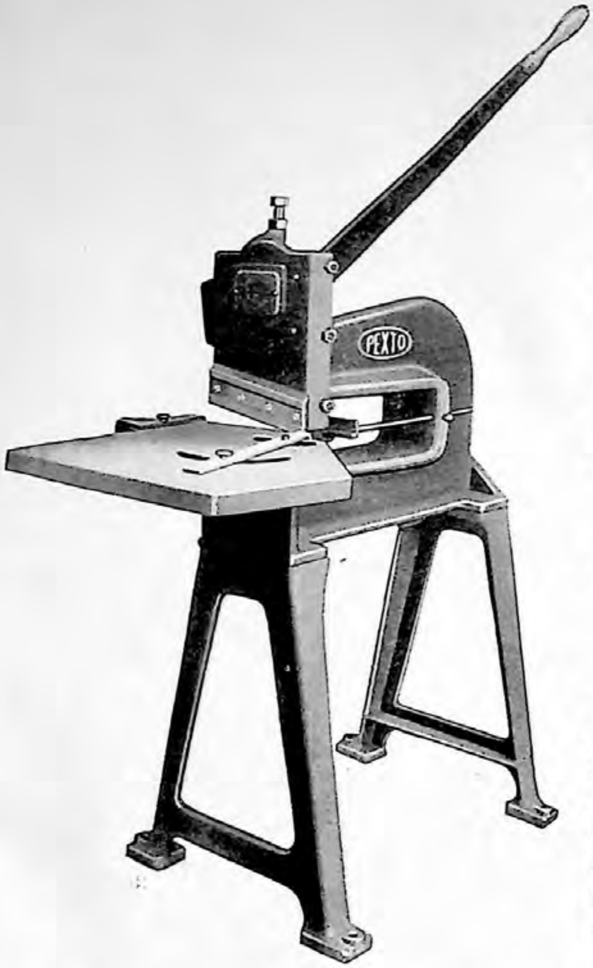
Number	250
Diameter Cutters ....ins.	3
Cutting Head depth ....ins.	9½
Cutting Head depth to Gauge ....ins.	9
Shipped boxed ....approx. lbs.	100

A compact shears for light trimming and slitting. Inexpensive, durable and practical.



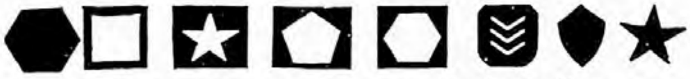
No. 250
Furnished with Bench Standard, Table and Gauge

UTILITY LEVER SHEARS



Well adapted for slitting and a variety of notching, straight and irregular cutting and for cutting inside of sheets without cutting the outer edge as illustrated below.

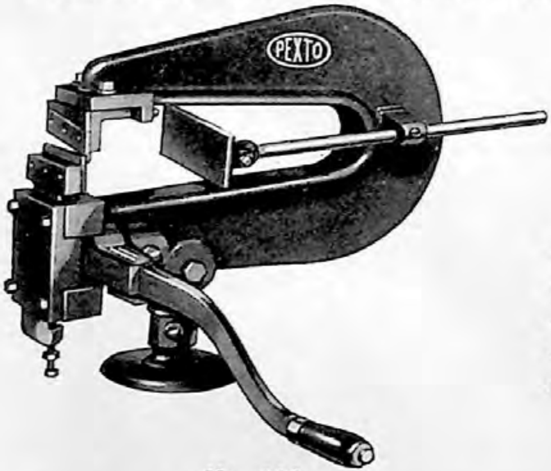
Provided with an adjustment for regulating the length of cut required. Lower knife is stationary, the upper knife holder is movable and is fitted with hand lever and counterbalance. A convenient table fitted with angle gauges is included. The cutting head is provided with a gauge for slitting.



Illustrations of work cut from blanks to line.

Number	248	241
Capacity soft steel ....Gauge No.	18	12
Length of cut ....ins.	6 ½	9
Cutting Head, depth ....ins.	10	19 ¼
Cutting Head, depth to Gauge ....ins.	9 ½	18 ½
Size of Table..................ins.	12x15 ½	16x20
Shipped Boxed ....approx. lbs.	180	......
Shipped on Skids ....approx. lbs.	......	500

No. 241 furnished with Floor Legs — Capacity No. 12 gauge soft steel and lighter.
No. 248 is a Bench Machine furnished without Floor Legs — Capacity No. 18 gauge soft steel and lighter.



No. 269

SCROLL SHEARS

Capacity — No. 20 gauge soft steel and lighter

Number	269
Length of cut..................ins.	4 ¼
Cutting Head, depth ....ins.	18 ¼
Cutting Head, depth to Gauge ....ins.	17
Shipped boxed ....approx. lbs.	140

For irregular cutting like the above illustrations and so patterned to allow for the cutting on the inside of a sheet without cutting the outer edge. Practical for slitting for which an adjustable gauge is fitted.

Mounted in a standard adjustable to any angle. Provided with an adjustment for regulating the length of cut required. Upper knife is stationary and can be adjusted for wear. Lower knife is movable and operated by a convenient hand lever.

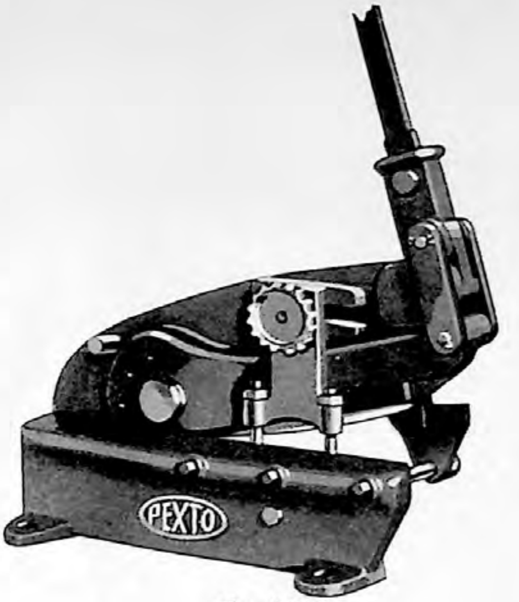
LEVER SLITTING SHEARS

Capacity — No. 10 gauge soft steel and lighter

Will cut bar iron ¼ x 1½ ins. maximum

Number	**0296**	With Rod Cutter **R0296**
Length of cut ....ins.	7¾	7¾
Length gauge rod ....ins.	14½	14½
Shipped boxed ....approx. lbs.	175	180

Furnished regularly as a plain Slitting Shears. Special when furnished with rod cutting attachment for cutting rods up to ½ inch in diameter.



No. 0296

PURPOSE — Commended for the slitting of sheets length or crosswise and the design is such as to allow sheets to pass freely and proportioned to obtain the greatest strength and durability.

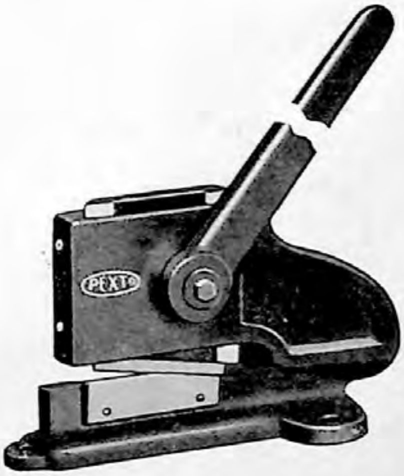
SPECIFICATIONS — A rigid frame of cast steel supplied with a hold-down to prevent wedging of knives. Hand lever is steel.

Long life and good service will depend largely on the care exercised in keeping up adjustments provided for the knives and the sharpness of knives.

CUT OFF SHEARS

Capacity — No. 16 gauge soft steel and lighter

Number	**253**
Length of cut ....ins.	3½
Length overall including lever ....ins.	18
Weight ....approx. lbs.	17

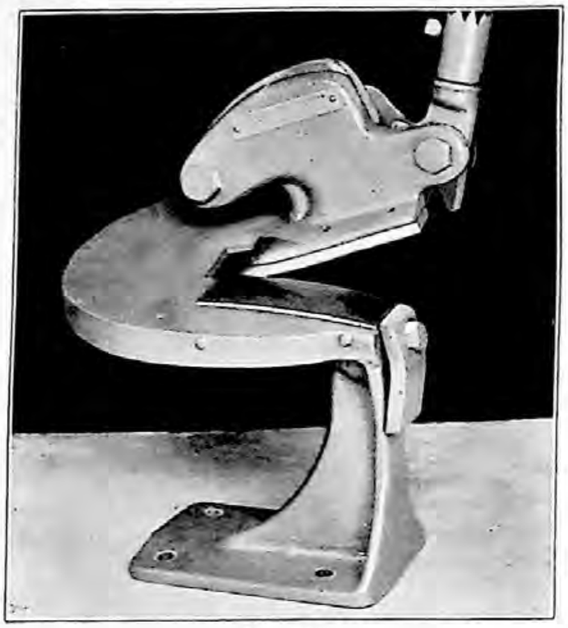


No. 253

PURPOSE — An inexpensive shears that may be used as a cut off or slitting shears. Its eccentric cutting device requires little effort when cutting up to the maximum capacity. A handy bench machine and easily carried to the outside job. With special beveled knives it makes a desirable Brake Band Lining Cutter for brake band lining up to ⅜ x 3 inches. For cutting brake band lining specify No. 252.

BEVERLY THROATLESS SHEARS

(PATENTED)



No. 310

Capacity—10 gauge soft steel and lighter

Number	314	310
Capacity—soft steel and lighter........gauge	14	10
Length of blade........ins.	4¼	4⅜
Shipping weight........approx. lbs.	20	40
Packed as ordered.		

A new and unique Throatless Lever Shear for both straight and irregular cutting.

The frame is made of high grade chrom-nickel steel for maximum strength combined with light weight.

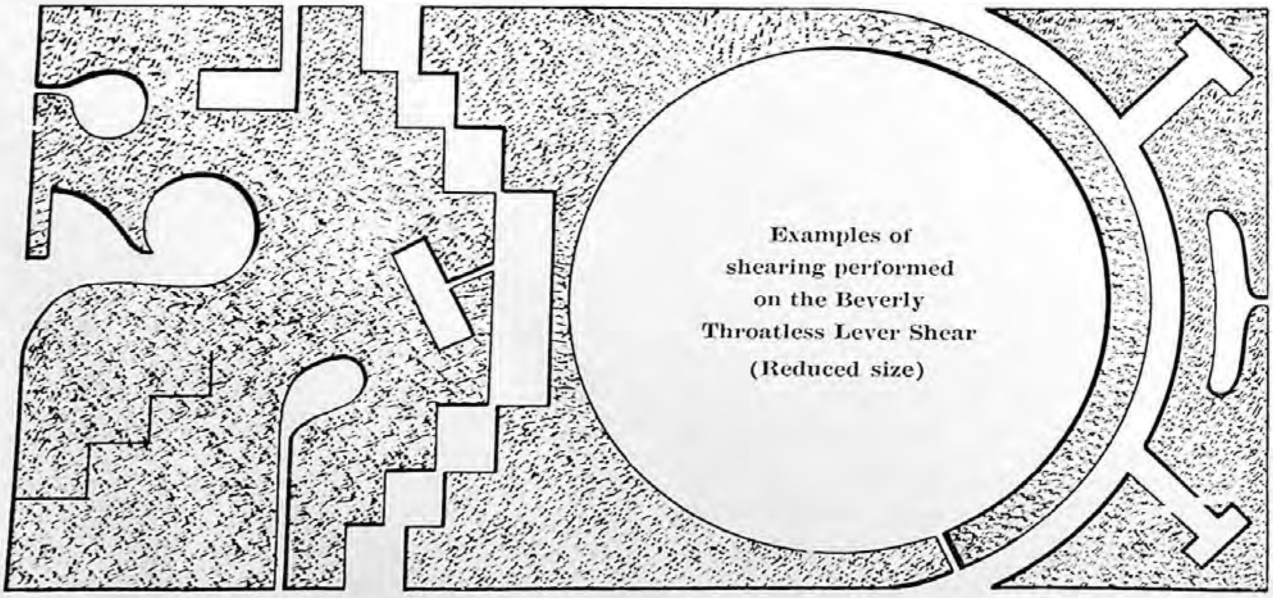
Starting the cut from the edge of sheet this throatless frame permits shearing sheet metal of any length. This special design makes it practical to turn metal in any direction while cutting, allowing any shape to be cut on the lighter materials without distortion. Also well adapted for notching work as illustrated below.

Top blade is actuated through rack and pinion and convenient length hand lever, giving great power with little effort.

Blades are made from highest grade tool steel properly hardened, adjustment provided for wear and quickly interchangeable. Cutting edges of blades are straight with top and bottom surfaces curved for greater shear and clearance when cutting intricate shapes.

The smooth cutting edges of blades produce a CLEAN-CUT SHEARED EDGE, FREE FROM KNURL OR OTHER MARKS AND ELIMINATING NECESSITY OF FILING OR TOUCHING-UP so objectionable to the aircraft industries and other fabricators of duraluminum and other alloy metals.

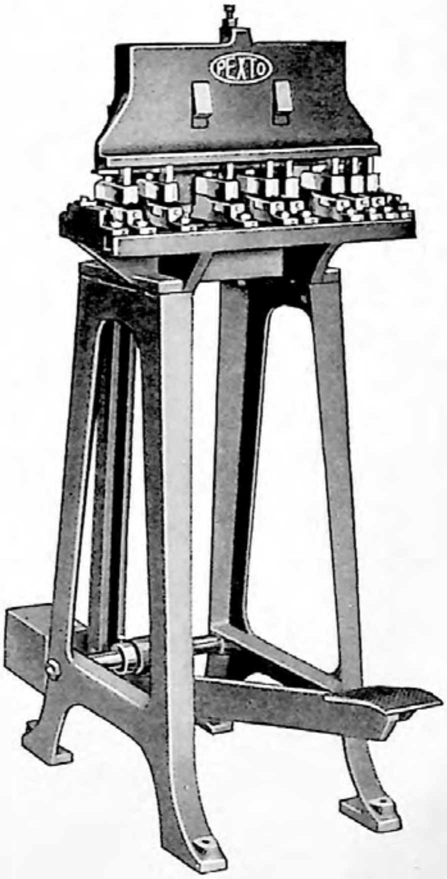
These shears have many uses that cannot be fully described on this page but the illustration below will give a fair example of their application.



Examples of shearing performed on the Beverly Throatless Lever Shear (Reduced size)

Bulletin F-35

PUNCHING AND NOTCHING MACHINES

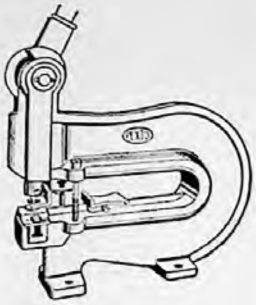


The great durability inherent in Pexto machines are familiar to thousands of users. This tested efficiency is the most convincing proof of Pexto dependable machine performance.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

LEVER PUNCHING MACHINES



SAMSON PUNCHES

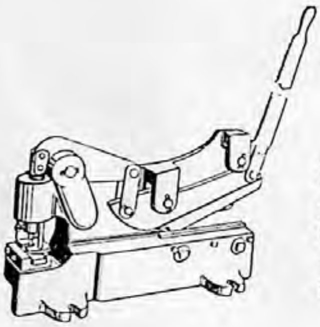
Number	675	676
Capacity with Stay Bolts in place	No. 9 Gauge Iron	3/8" Hole 5/16" Iron
Capacity with no Stay Bolts	No. 12 Gauge Iron	3/8" Hole 3/16" Iron
Depth Throat to Frame ....inches	15	15
Depth Throat to Gauge ....inches	14½	14½
Will center Sheets with Stay Bolts in place. width ins.	7	7
Will center Sheets with Stay Bolts removed. width ins.	30	30
Shipped boxed regularly ....weight approx. lbs.	160	240

No. 675 Furnished regularly with three dies and three punches; viz.: 1/8, 3/16, 1/4 inches. Not adaptable for special punches and dies over 3/16 inches.

No. 676 Furnished regularly with three dies and three punches; viz.: 1/4, 5/16, 3/8 inches. We can furnish extra size dies and punches from 1/8 to 1¼ inches inclusive. Standard punch equipment provides for taking punches up to ½ inch. Any punching over ½ inch and to 1¼ inches inclusive requires one extra stripper and one extra bushing and one extra die holder.

No. 676 Can be furnished with special frame for punching up to 2 inches diameter at an extra charge.

These Punches are designed for strength and rigidity making them exceptionally useful machines for general work. Fitted with adjustable gauge and stay bolts for reinforcing frame for heavy punching.



SIMPLEX COMBINED SHEARS AND PUNCH

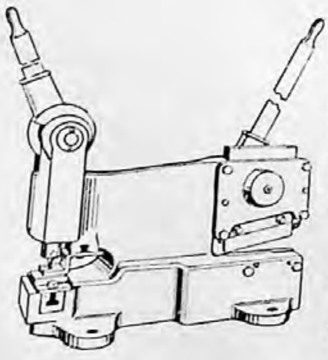
Number 679

Capacity — 3-8 inch hole in 3-16 inch iron. Will cut sheet iron No. 14 Gauge Soft Steel and Lighter and narrow bars 3-16x1 inch.

Number	679
Depth Punching Gap ....inches	2¾
Will Center Sheets ....width inches	5½
Length Cut ....inches	4¾
Shipped boxed regularly ....weight approx. lbs.	140

NOTE — Furnished regularly with punches, one each 1/8, 3/16, 1/4, 5/16, 3/8 inches and one combination die for 1/8, 3/16, 1/4, 5/16 and 3/8 inch punches.

A combination Shears and Punch offering a wide range of punching and cutting usefulness that make them highly adaptable for the general shop. Frame is so constructed as to permit cutting or slitting of sheets longer than length of blades.



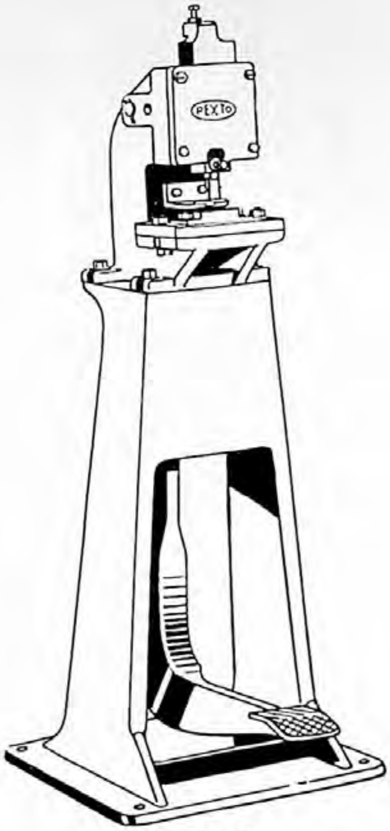
HEAVY COMBINED SHEARS AND PUNCH

Number	680
Capacity for Punching	3/8" Hole 5/16" Iron
Depth of Punching Gap ....inches	5
Will center Sheets ....width inches	10
Capacity for Shearing, will cut Sheet Iron ....Gauge No.	8
Length of Cut ....inches	6
Will cut Bar Iron ....inches	¼x1¼ 3/8x¾ or ½ inch square
Shipped crated regularly ....weight approx. lbs.	385

NOTE — Furnished regularly with three dies and punches; viz.: 1/4, 5/16, 3/8 inch.

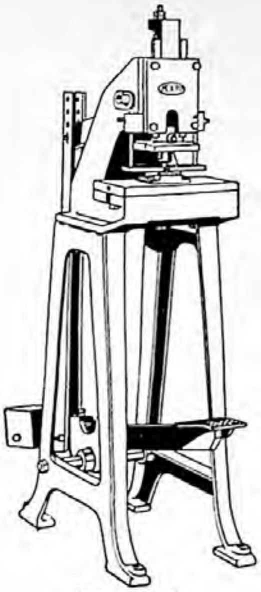
Compact and practical with independent punching and shearing units for heavy work. Substantially built and will punch and shear as recommended.

FOOT PUNCH PRESSES



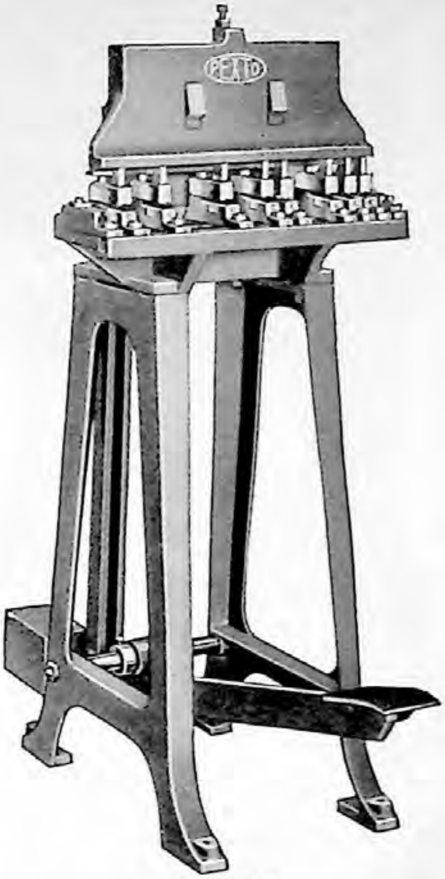
No. 1747

Capacity with Pivot Pin set for Min. Stroke
⅜″ Hole in 18 Gauge or equivalent



No. 1748

Capacity with Links and Lever
Adjusted for Min. Stroke
⅜″ Hole in 12 Gauge or equivalent



No. 1734
NEW GANG PUNCH

Capacity—Will punch nine ⅛ inch holes in 16 gauge soft steel and lighter

Number		1747	1748
Opening in bed	ins.	2 ½	8 ¼ x4 ½
Distance from center of slide to back	ins.	3	4 ¼
Distance from bed to slide when up	ins.	4	5
Maximum stroke of slide		1 ½	2 ½
Usual hole in slide	ins.	⁵⁄₁₆	1
Area top of bed and bolster	ins.	5 ½ x7 ½	7 ¼ x13
Thickness of Bolster	ins.	¾	1
Shipped regularly on skids	approx. lbs.	350	400

Furnished regularly without gauges, punches and die holders. No. 1748 furnished with legs. No. 1747 is furnished with iron floor pedestal, but can be omitted if so specified. Special dies and punches will be quoted on application.

Heavy and compact combining strength with convenience of operation, these presses offer useful machines. With the proper dies and gauges notching, light forming and special punching can be done.

They are built with great care, for meeting the special requirements of the more exacting buyer, and not to be compared with some of the very cheap presses the market is offering.

No. 1734 GANG PUNCH

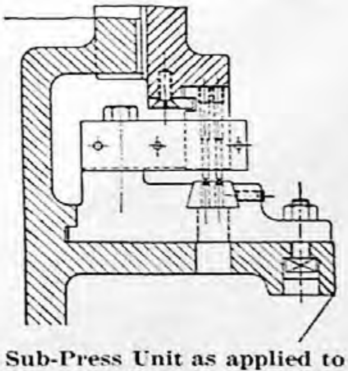
A feature of this Gang Press is found in the use of adjustable sub-press units as illustrated for convenient spacing of punches. Removing only one bolt for each sub-press unit these units can be shifted sidewise or taken out of the machine entirely. There is no time wasted in the accurate alignment of punches and dies.

Each unit is so constructed that two punches can be inserted, one in back of the other on a ⁵⁄₁₆ inch center distance.

These same units can be arranged for receiving dies and punches to punch larger than ⅛ inch and not greater than ³⁄₁₆ inch but which will necessitate special punch holders. Where the punches are larger than ⅛ inch, the punch holder and the die will be made for one single hole only.

The double set of holes provided in the regular ⅛ inch diameter punch holder and dies are intended to take care of the manufacture of riveted elbows or where two rivets are used side by side in such elbow sections having a narrow throat.

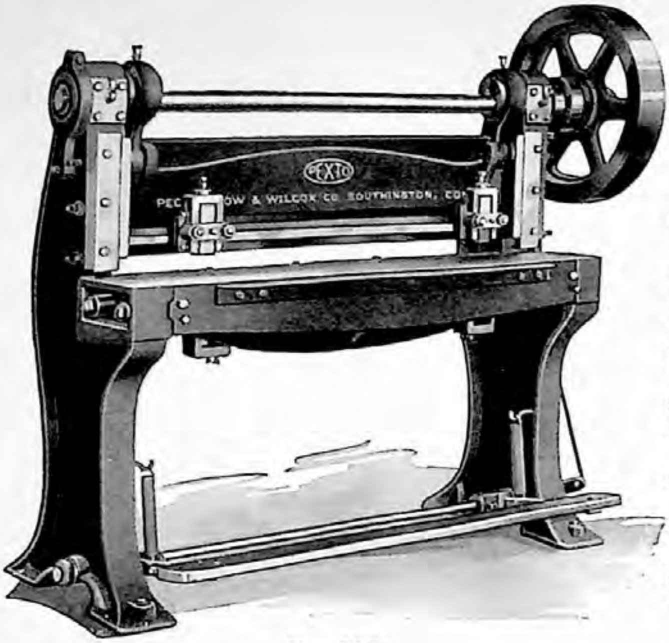
A desirable Gang Punch for punching elbow sections for elbows up to 12 in. in diam.



Sub-Press Unit as applied to No. 1734 Foot Gang Punch

Stroke of slide	ins.	⅜
Maximum center distance between end punches	ins.	19
Minimum distance between punches	ins.	1
Maximum distance from edge of sheet to center of hole (or depth of throat in unit)	ins.	1 ½
Shipped on skids regularly	approx. lbs.	400

Furnished with eight sub-press units with dies and nine punches for ⅛ inch holes including two gauge brackets with adjustable side and end gauges.



No. 207

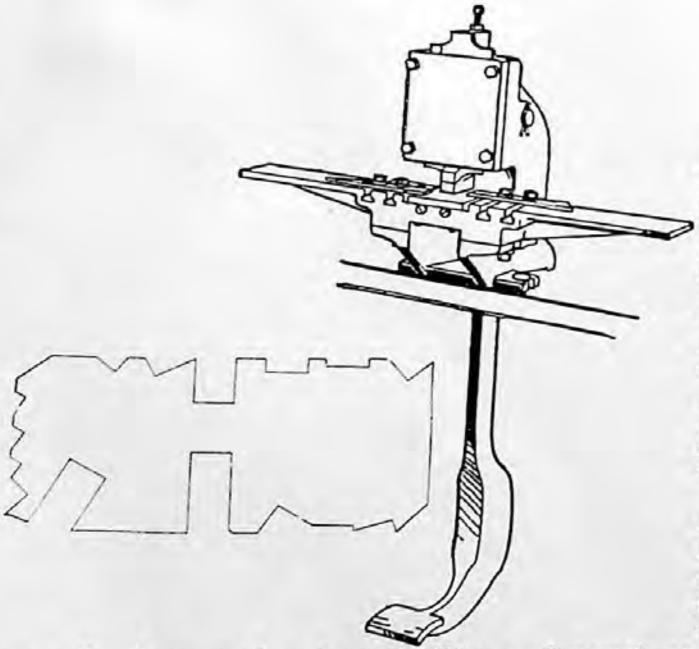
POWER DUPLEX NOTCHING MACHINES

(CAN ALSO BE ARRANGED FOR GANG PUNCHING)

Number	206	207
Standard stroke ins.	1½	1½
Will notch or punch in width ins.	30	42
Width between housings ins.	40	52
Size of flywheel ins.	28x4	28x4
Weight of flywheel lbs.	300	300
Speed of flywheel R.P.M.	75	75
Motor requirements—flat belt or V belt motor drive H.P.	¾	¾
Speed of motor—flat belt motor drive R.P.M.	900	900
Speed of motor—V belt motor drive, geared head motor R.P.M.	507	507
Shipped on skids regularly, approx. lbs.	1500	2000

The PEXTO line offers Single as well as Double End or Duplex Notching Machines. The patterns shown here are fitted with adjustable die and punch holders. The notching punch and dies are adjustable for notching two corners of blank at each stroke. A number of blanks may be notched together up to the capacity of the machine. This machine can be conveniently arranged for gang punching with the addition of the necessary extra attachments.

Front and side gauges form a part of the regular equipment. Notching dies and punches are special and in order to quote on same sketches must accompany inquiries.



FOOT NOTCHING MACHINE

Capacity — 2 x 2 inch notch No. 20 gauge soft steel or equivalent

Number	737
Size regular dies ins.	2x2
Capacity for receiving special dies up to ins.	2x2
Length of gauge support ins.	13½
Shipped boxed regularly weight approx. lbs.	225

NOTE: — Furnished complete with one set regular dies and full equipment of gauges. Special dies quoted on application.

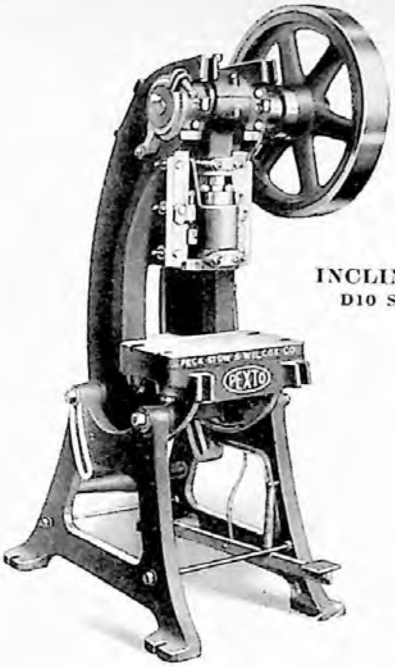
Furnished regularly for bench use which requires a cutout in bench. Floor pedestal is recommended for more rigid mounting and can be furnished at small extra cost.

An exceedingly well constructed, pendulum lever Notching Machine intended for notching blanks of pieced sheet metal ware, for cutting the corners of square pans and hinge notches of boxes and similar work. Dies are made in sections, so that they may be easily sharpened and reset. Dies and punch are made from Jessop tool steel, scientifically hardened and tempered. A most convenient Notching Machine of high-grade quality for bench use.

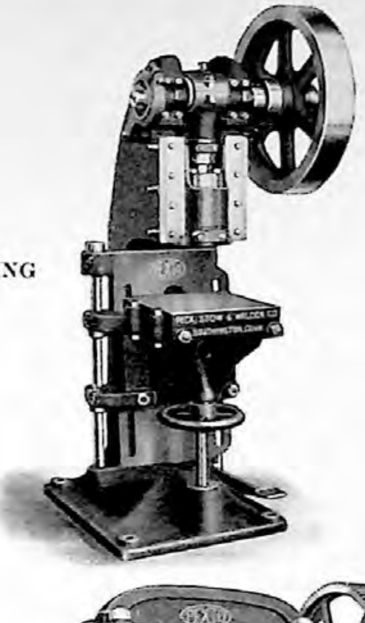
The distinctive principle of gauging with this improved machine permits for square and V notching.

POWER PRESSES

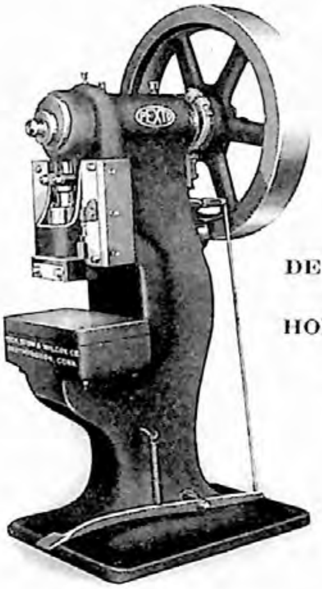
See Chart Page 36



INCLINABLE
D10 SERIES

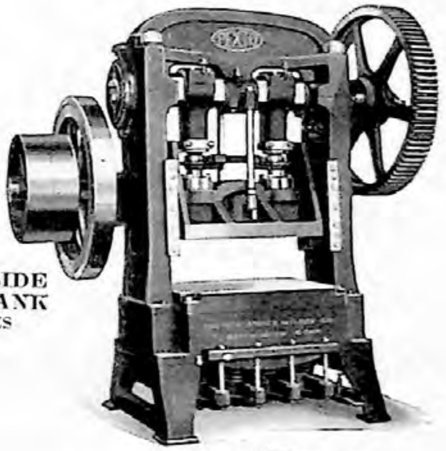


HORN AND SEAMING
D23 SERIES

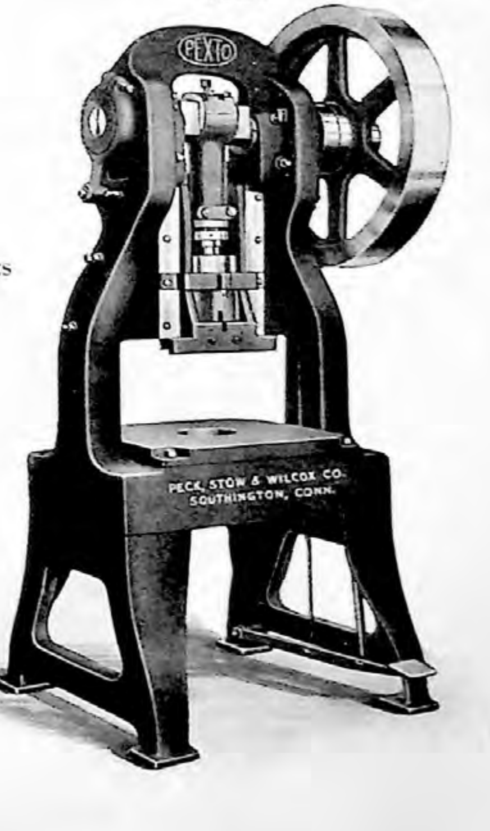


DEEP GAP PUNCHING
D40 SERIES

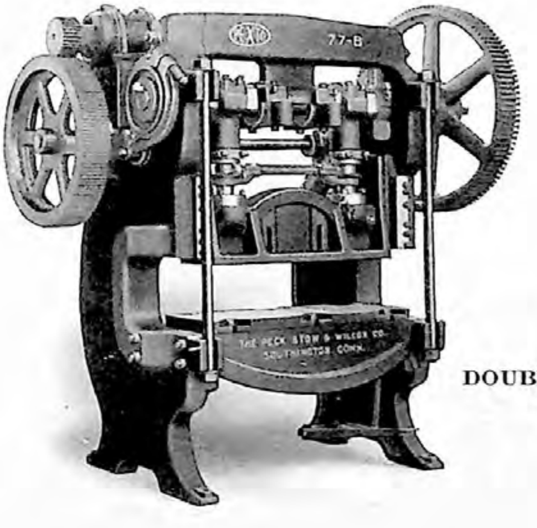
HORN PUNCHING AND RIVETING
D126 SERIES



STRAIGHT SIDE DOUBLE CRANK
DA136 SERIES



ARCH
DA55 SERIES



DOUBLE CRANK GAP
DA76 SERIES

D for Direct Acting
Affix G instead of D for Geared

POWER PRESS CHART

Illustrations Page 35

Pattern	Numbers	Tons Capacity	Diameter Crank Shaft in Bearings Inches	Bed to Slide Stroke down Adjustment up Inches	Standard Stroke Inches	Maximum Stroke Inches	Bolster Plate Dimensions Inches	Depth Back from Center of Slide Inches	Opening in back Inches	Weight Flywheel, Lbs. Direct Acting	Weight Press Lbs.
INCLINABLE	D10	3	1⅜	4¾	1	1½	⅞x8x11	4⅜	7½	55	Bench 450
	D13	8	1⅞	5⅞	1½	3	1¼x8½x14	4¼	7	175	900
	D14	14	2¼	6¾	2	4	1½x10¾x17¾	5⅛	8¼	300	1600
	DB14	14	2¼	9¼	2	4	1½x12x20	6½	10½	300	2000
	D15	27	3	8	3	5	2x15x22	8	11	500	3000
	D16	45	3½	9½	3½	6	2½x19x28⅝	9½	14½	750	4800
	D17	65	4½	11	4	6	2½x19x31	9½	13¾	1100	7000
HORN WIRING AND SEAMING	D23	7	1⅝	Distance from Top of Hole in Frame 3⅝	1½	3	1½x10½x14	5¼		175	1150
	D24	14	2¼	5½	2	4	2x16x15½	8¼		300	2200
	D25	27	3	5½	3	5	2x19¾x25	10		500	4400
	D26	45	3½	8	3	6	3x23x28	12		750	7000
	D27	65	4½	11⅝	3	6	3x27x31	14		1100	9800
GAP PUNCHING	D40	2	2	3¼	¾	......	⅞x8x8	4		30	200
	D44	14	2½	7¾	1½	2½	1½x10x15	6		300	1350
	D144	15	2¾	7	1	2½	2x8x12	6			1300
	D45	25	2 15/16	8	1½	2½	2x10½x18	6⅝		500	2200
	D46	40	3 11/16	8¼	1½	3	2½x12x20	6⅜		750	3500
	D47	60	4⅜	9	1½	3½	2½x16x24	8¾		1100	6000
	D48	85	5⅜	10¼	1½	4	3½x19x29	12¼		1500	8500
	DA104	14	2½	7½	1½	2½	1½x10x15	20		300	2300
	D105	25	2 15/16	7	1½	2½	2x10½x18	20		500	3200
	D107	60	4⅜	9⅛	1½	3½	2½x16x24	30½		1100	9200
HORN PUNCHING & RIVETING	D126	40	3 11/16	From Top of Horn 8	1½	3½	....	24¼		750	5700
	DA127	70	5	8½	1½	3½	....	24		1100	12000
	D127	60	5	8½	1½	3½	....	32½		1100	13000
STRAIGHT SIDED DOUBLE CRANK	DA136	56	4	11	3	5	2½x26x36	Double Crank Gap and Heavier Straight Sided Presses than listed on application	Distance between Housings 36½	1000	6500
	DB136	56	4	11	3	5	2½x26x48		48½	1000	9000
	DA137	88	5	12	3	7	3x32½x35½		36½	1300	10500
	DB137	88	5	12	3	7	3x32½x41½		42½	1300	12500
	DC137	88	5	12	3	7	3x32½x47½		48½	1300	13500
	DA138*	126	6	14	3	10	4x32½x37¼		38¼	1800	18000
	DB138*	126	6	14	3	10	4x42x47¼		48¼	1800	19500
	DC138*	126	6	14	3	10	4x42x53¼		54¼	1800	22500
DOUBLE CRANK GAP PRESSES	DA175	20	2 15/16	6	1½	3	Bed 8¼x23	3	24	500	2500
	DB175	20	2 15/16	6	1½	3	8¼x32	3	33	500	2900
	DC175	20	2 15/16	6	1½	3	8¼x38	3	39	500	3200
	DD175	20	2 15/16	6	1½	3	8¼x44	3	45	500	3600
	DE175	20	2 15/16	6	1½	3	8¼x48	3	49	500	4000
	DF175	20	2 15/16	6	1½	3	8¼x65	3	66	500	5300
Can furnish No. 76 series with special gap center slide to frame 13″	DA76	56	4	11	2	5	2x16x36	7¾	36	1000	7000
	DB76	56	4	11	2	5	2x16x48	7¾	48	1000	8500
	DC76	56	4	11	2	5	2x16x60	7¾	60	1000	9500
	DD76	56	4	11	2	5	2x16x72	7¾	72	1000	11000
	DA77	88	5	12	3	5	2½x18x36	9¼	36	1300	11000
	DB77	88	5	12	3	5	2½x18x48	9¼	48	1300	12500
	DC77	88	5	12	3	5	2½x18x60	9¼	60	1300	14000
	DD77	88	5	12	3	5	2½x18x72	9¼	72	1300	15500
Can furnish No. 79 series without gap in housings	GB79 Made Geared only	160	6¾	14	3	7	3½x30x48	10	48	1500	26000
	GC79	160	6¾	14	3	7	3½x30x60	10	60	1500	29000
	GD79	160	6¾	14	3	7	3½x30x74	10	74	1500	32000
	GE79	160	6¾	14	3	7	3½x30x84	10	85	1500	38000
ARCH	DA55	37	3¼	8⅞	3	5	2x25½x28		29	500	3600
	D56	56	4	11	3	6	2¼x25¾x28¾		30	750	5800
	D57	88	5	12	3	6	2½x26x29		30	1300	8200

NOS. MARKED (*) CAN BE FURNISHED IN FOUR PIECE TIE-ROD CONSTRUCTION.

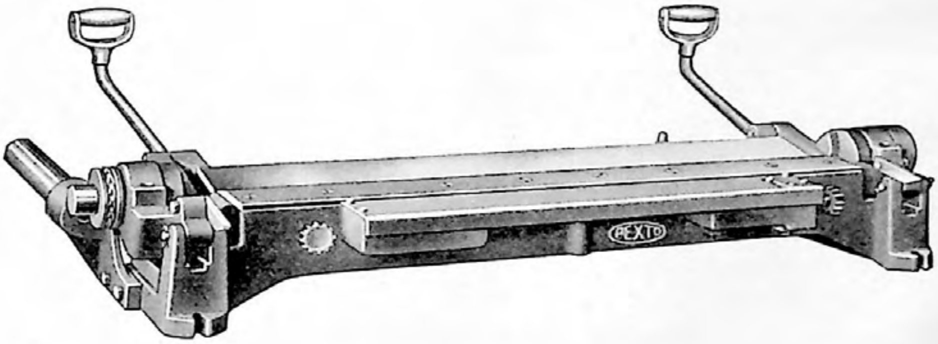
PEXTO

Bulletin G-35

FOLDING MACHINES

AND

BRAKES

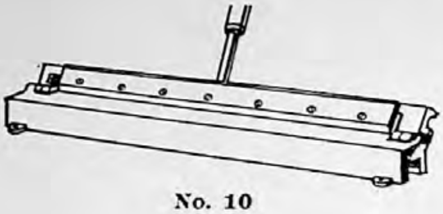


The time tested factors of design and construction has given Pexto Machines the endorsement of engineers and sheet metal contractors for providing desired accuracy, high productive capacity, ease and economy of operation.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

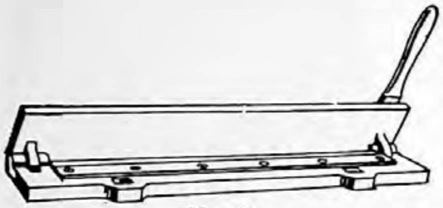
IMPROVED SHEET IRON FOLDERS



No. 10

Number		10	15
Capacity soft steel and lighter	Gauge	22	24
Length for Sheets	width ins.	30	42
Will form Locks	ins.	¼ to ½	¼ to ½
Shipped boxed regularly	weight approx. lbs.	85	115

IRON BOTTOM SHEET IRON FOLDER



No. 2

Number		2
Capacity soft steel and lighter	Gauge No.	22
Length for Sheets	width ins.	30
Will form Locks	ins.	3/16 to ⅝
Shipped boxed regularly	weight approx. lbs.	105

Both types of Folders on this page are of all iron construction, carefully machined, fitted with planed steel Bending Blades, and where a handy Folder is required for ordinary use, they will give excellent satisfaction.

Gauge of Folders Nos. 10 and 15 move on a slide. A center support is provided on under side of frame. When setting up machine this support should be shimmed to prevent deflection of frame when folding takes place. Gauge of Folder No. 2 is fitted under the Folding Plate and Folding Plate screws must be loosened before gauge can be moved.

BRACE AND WIRE BENDER

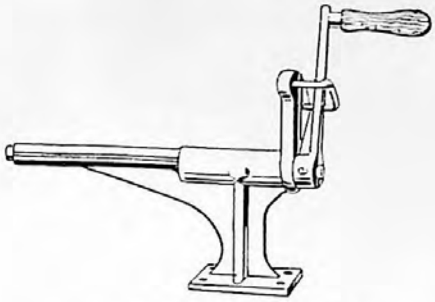
No. 402

Number		402
Width of Bending Plate	ins.	2
Will form Wire	ins. diameter	⅜
Size of half round grooves in Top Plate	ins.	⅛ - 3/16 - 5/16 - ⅜
Shipped boxed regularly	weight approx. lbs.	60

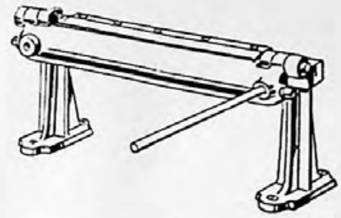
NOTE:—Handle may be used in center or at either end of machine. When ordered for wire bending exclusively, a hardened Steel Plate is recommended and can be furnished at a minimum extra charge when so ordered.

A substantial Brace and Wire Bender intended for making Braces for Lookouts, Gutters, Leaders, Cornices, etc. It will bend iron of any size up to ¼-inch thick, 2 inches wide from 0 to 90 degrees. The Top Plate is adjustable for turning sharp or round corners and for different thicknesses of metal, regulated by means of the Hold-Down and Set Screws in the Top Plate and Set Screws at the back of the Plate. One side of the Top Plate is cut with grooves in several sizes, and when reversed, wires can be bent for Pans, Boxes, etc. Several wires can be bent at the same angle at one operation.

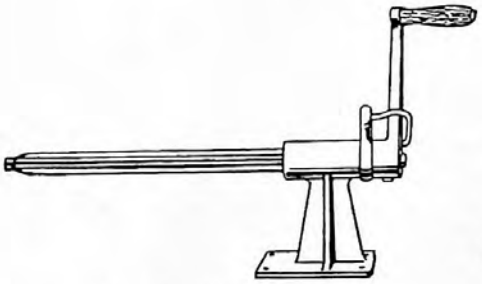
SPECIAL FOLDERS



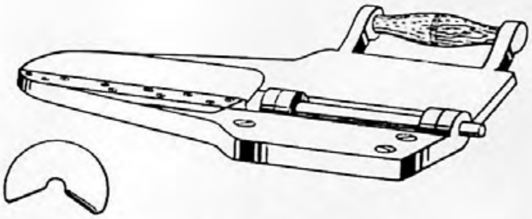
Taper Edger No. 485



Body Blank Folder No. 0212



Handy Folder No. 486



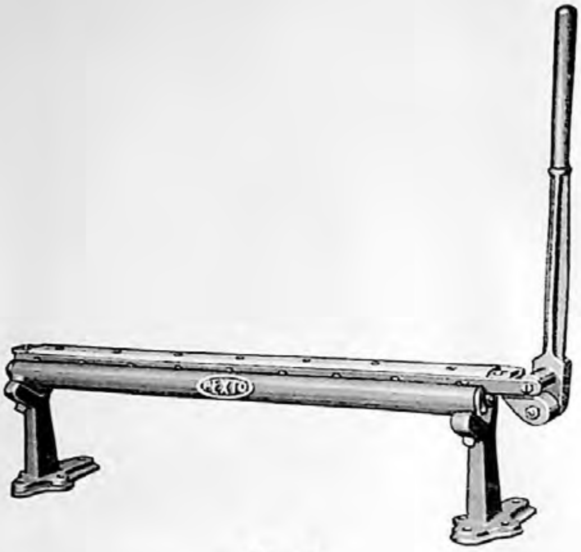
Can Top Folder No. 6—16

Number	485	0212	486	6	16
Capacity Gauge Iron and Lighter ...... No.	26	24	26	26	26
Length .... inches	10	12	14	10	13
Will form Locks .... inches	⅛	⅛ to ¼	⅛	⅛	⅛
Shipped packed as ordered, wt. approx. lbs.	11	45	20	20	50

These Folders are not carried in stock but are made special to order. Detailed information and prices will be given on request. It will be noted that the Can Top Folding Machine is made up regularly for one size of lock ⅛ inch but can be arranged for wider locks. The Can Top Folder is used for edging blanks such as oil can breasts. The Taper Edger will turn a lock on tapering work such as funnels after being formed into shape. The Body Blank Folder will prove useful for folding the edges for side seams of can bodies two and one-half inches in diameter and larger after being formed. The Handy Folder will form locks on tubes one and one-half inch in diameter and larger after same are formed.

PIPE FOLDERS

CHAMPION FOLDER


No. 11

Capacity — No. 24 gauge soft steel and lighter

This machine will work No. 22 gauge but not for steady use

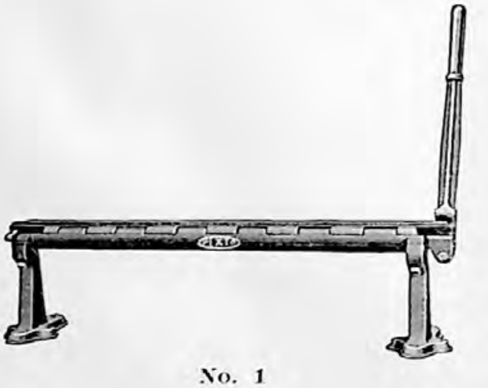
Number		**11**	**13**
Length for sheets	width ins.	30	42
Will form locks	ins.	3/16 to 7/16	¼ to ½
Shippd boxed reguarly, wgt. approx. lbs.		100	200

NOTE:—No. 13 Folders have a handle at each end, one of which can be removed when not required.

We commend these machines for folding the edges for the side seams of round pipe, after being formed, as well as for folding the edges of straight sheets. Their improvement over the Wright's Patent Sheet Iron Folders, consists of an adjustable sliding gauge. Variations in the hardness of the material will have no effect upon the uniformity of the lock. Their construction does not permit for folding a lock on pipe as close as the Wright Pattern Pipe Folder, for which reason the Wright Folder is sometimes preferable. For folding the edges of flat sheets and forming locks on pipe of stiff iron, the patterns shown here will prove more substantial, and will outlast the Wright's Pattern Pipe Folder. Late improvements have served to greatly increase its precision and accuracy.

WRIGHTS FOLDER

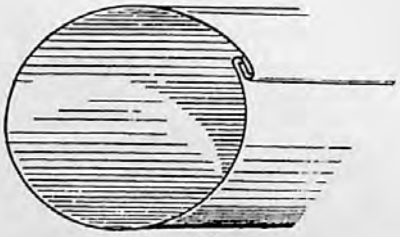
Capacity — No. 24 gauge soft steel and lighter


No. 1

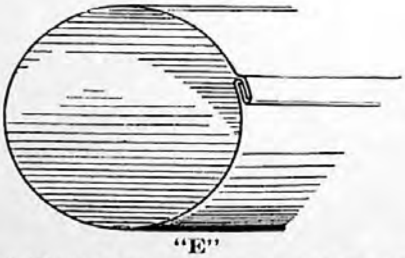
Number		**1**
Length for sheets	width ins.	30
Will form locks	ins.	¼ and ⅜
Shipped boxed regularly	weight approx. lbs.	80

These Folders will fold the edges of sheets previously formed in a cylindrical shape. They will prove desirable machines for edging sheets while in the flat as well.
For folding the edges of pipe of light material for stove pipe, etc., these patterns are preferable over the Champion Pattern Pipe Folder, as they will close down the lock ready for grooving with little or no malleting.

Gauge is adjustable for forming two sizes of locks, viz.: ¼ and ⅜ inches. Using strips of No. 22 gauge spring steel cut of correct width and placed under lip of folding blade locks ½ and ⅝ inch can be formed. For forming ¼ and ⅜ inch locks the following directions should be observed. For locks ¼ inch: Throw hand lever to left as far as it will go. Turn thumb screw at right in. Turn thumb screw at left out. For locks ⅜ inch: Throw hand lever to left. Turn thumb screw at left in and turn thumb screw at right out.


"D"

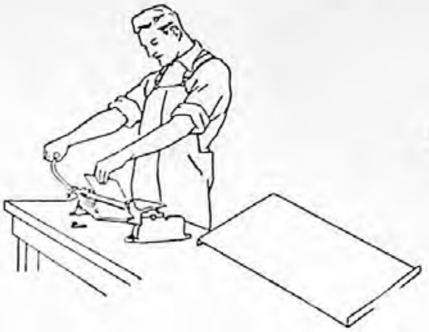
"D" illustrates edge formed on Pipe Folder after sheet has been formed on Forming Machines illustrated on pages 52 and 53.

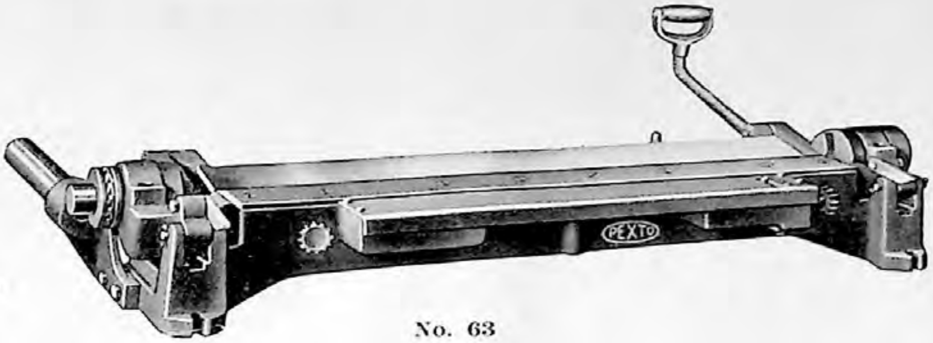

"E"

"E" illustrates side seam grooved and flattened on Grooving Machines as shown on pages 70 and 71.

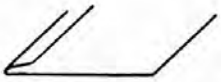
IMPROVED ADJUSTABLE BAR FOLDER

(PATENTED)

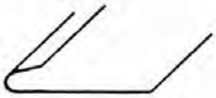




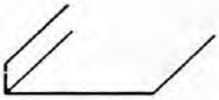
No. 63



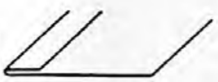
SHARP LOCK



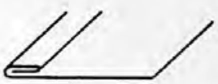
OPEN LOCK FOR WIRE EDGE



90 DEGREE FLANGE



CLOSED LOCK OR SINGLE HEM



DOUBLE HEM

Number	62	63	055	058
Length for sheets ....ins.	20	30	36	42
Capacity, soft steel ....Ga.	22	22	20	20
Gauging range Closed or Open Locks....ins.	1/8 to 1	1/8 to 1	1/8 to 1 1/4	1/8 to 1 1/2
Minimum width of folds, maximum cap'y ..ins.	3/16	3/16	3/16	3/16
Minimum width of folds, 22 ga. soft steel....ins.	3/16	3/16	3/16	3/16
Minimum width of folds, 24 ga. soft steel....ins.	1/8	1/8	1/8	1/8
Minimum width of folds, 28 ga. soft steel....ins.	3/32	3/32	3/32	3/32
Round folds for wire, maximum diameter....ins.	1/4	1/4	3/8	3/8
Shipped boxed ....approx. lbs.	140	220	420	520

NOTE:—All numbers are regularly furnished with spring counterbalance attachment excepting No. 62. Counterbalance can be applied to No. 62 Folder at extra charge. Nos. 055 and 058 regularly supplied with two handles.

USES AND OPERATION — Adapted for forming the edges of sheet metal at various angles to form locks and square joints. Open or round folds such as for wire inlaying are made by adjusting Wing on the Folding Bar.

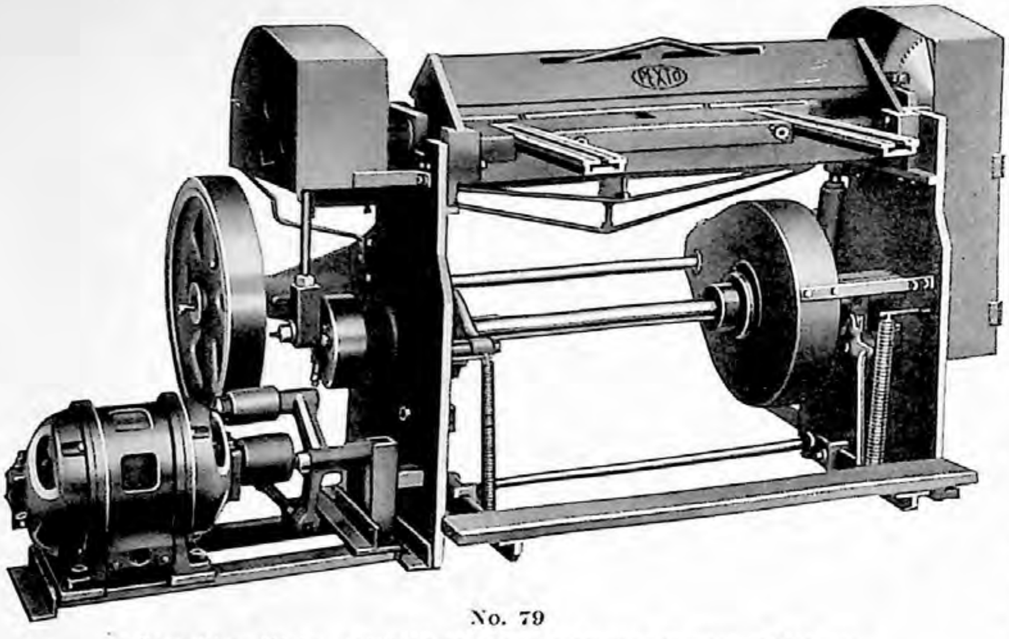
Gauge is adjustable and regulates the width of fold by turning of Gauge Screw Knob at right end of machine and is securely locked with a screw knob on left. Provided with direct reading scale in fractions of inches with indicator to show how the Gauge is set.

Steel Stops for 45 and 90 degree bends are fitted on each end. In addition Adjustable Stop is provided to permit the forming of any desired angle.

A Gripping Jaw clamps the material securely while the bending takes place, forming narrow or wide edges of uniform width the entire length.

IMPROVED FEATURES — Adjustable Gauge Bar has two bearings one on each end, with a connecting center bar producing an extremely rigid construction. Fitted in a fully-machined Frame, there can be no forcing the gauge out of line on the ends causing inaccurate locks. Folding Blade is high carbon steel, and heat treated for proper hardness of the folding edge for endurance and long life. The Folding Bar is made extra heavy against springing but this extra weight is not felt in lifting the folding bar when folding up to capacity. It is counterbalanced by means of an encased compression spring attachment, self contained and which fastens directly to the Folder and is adjustable for varying tension.

POWER FOLDER AND BRAKE



No. 79

Capacities: Minimum Width of Locks on Various Gauges of Material.

$\frac{3}{8}$ inch Lock on No. 24 gauge Soft Steel.
$\frac{7}{16}$ inch Lock on No. 22 gauge Soft Steel.
$\frac{1}{2}$ inch Lock on No. 20 gauge Soft Steel.
$\frac{5}{8}$ inch Lock on No. 18 gauge Soft Steel.

Capacity with Special Blades for Acme Lock Knocked down stove pipe — 24 gauge Soft Steel.
Capacity with Special Blades for Security Lock Knocked down stove pipe — 24 gauge Soft Steel.

Operation

On the front of the machine or the operator's side gauge brackets are provided with graduations from 1 to 24 ins. Narrow locks are gauged against the back gauges located on folding blade side or back of machine. Motion of the clamping and the folding bar is controlled by a positive safety non-repeat square pin clutch.

Crank discs on each side are provided with adjustment for regulating swing of the folding bar. The sheets are fed between bed and clamping jaw and automatically clamped before the folding operation is performed immediatly after treadle has been depressed.

Clamping bar has 1¼ inch motion.

Construction

All main members are constructed of welded steel. Gears are semi-steel and pinions are of solid steel machine cut. Bearings are bronze bushed except drive shaft bearings which are babbitted.

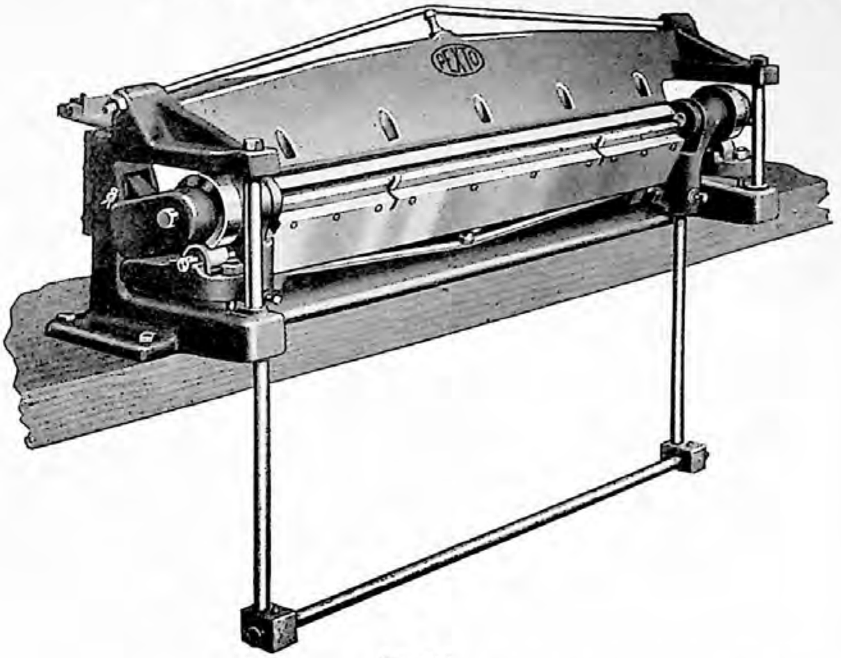
All folding members are reinforced by means of truss rods serving to reduce deflection to a minimum.

A folding blade and a bed insert and clamping blade are included as standard for plain folding but special blades and inserts can be applied for nested stove pipe folds. A very sturdy machine for large production.

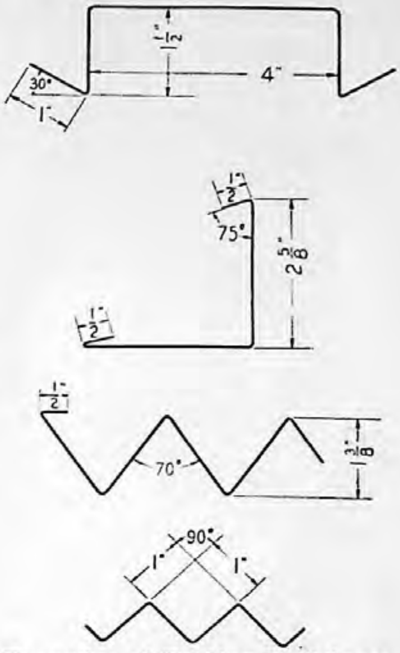
Number	79	80
Length for Sheets ....width inches	36	42
Size of Fly Wheel ....inches	22x3	22x3
Speed of Fly Wheel ..................................R.P.M.	240	240
Weight of Fly Wheel ....Lbs.	225	225
Ratio of Gearing	4:1	4:1
Horse Power required ...................................H.P.	3	3
Speed of Motor ....R.P.M.	1200	1200
Size of Motor Pulley required ....inches	4½x3½	4½x3½
Back Gauge Range, maximum ....inches	1	1
Front Gauge Range, minimum—maximum ....inches	1–24	1–24
Shipped on Skids, weight ....approx. lbs.	1800	2200

NOTE:—Can be furnished for flat or V belt individual motor drives. Flat belt motor drive includes motor bracket, self adjusting idler or belt tightener. V belt motor drive includes motor bracket, motor pulley and V Belt. Motor and electrical equipment not included unless specified at an extra charge in which case complete available current specifications should be given.

SINGLE MOTION COMBINATION FOLDER AND BRAKE



No. 64

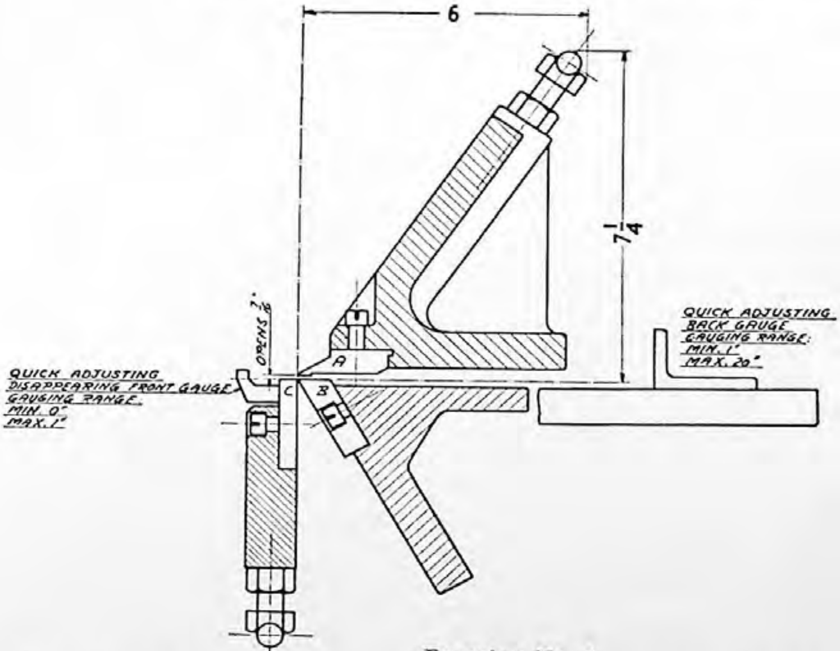


Examples of Folding Usefulness

Capacity—$\frac{3}{16}$ inch locks and wider on No. 24 gauge soft steel
$\frac{5}{16}$ inch locks and wider on No. 20 and 22 gauge
½ inch locks and wider on No. 18 gauge

Number		64
Length for sheets, width	ins.	30
Shipping weight, boxed	approx. lbs.	425

NOTE:—Shipped regularly for bench use. Floor legs can be furnished at extra cost.


6
7¼
OPENS ⅛"
A
B
C
QUICK ADJUSTING DISAPPEARING FRONT GAUGE GAUGING RANGE. MIN. 0" MAX. 1"
QUICK ADJUSTING BACK GAUGE GAUGING RANGE: MIN. 1" MAX. 20"

Drawing No. 1

A new Folder and Brake that derives its name (single motion) because it is different from other Folders or Brakes of its kind. The sheet to be folded is clamped automatically on raising the bending leaf in the usual manner when forming the lock or angle. Built on the Brake principle the jaws are open from front to back. With the application of the clamping feature of the well-known Bar Folder, a new departure in practical Folding Machine construction for utility, speed and accuracy is offered.

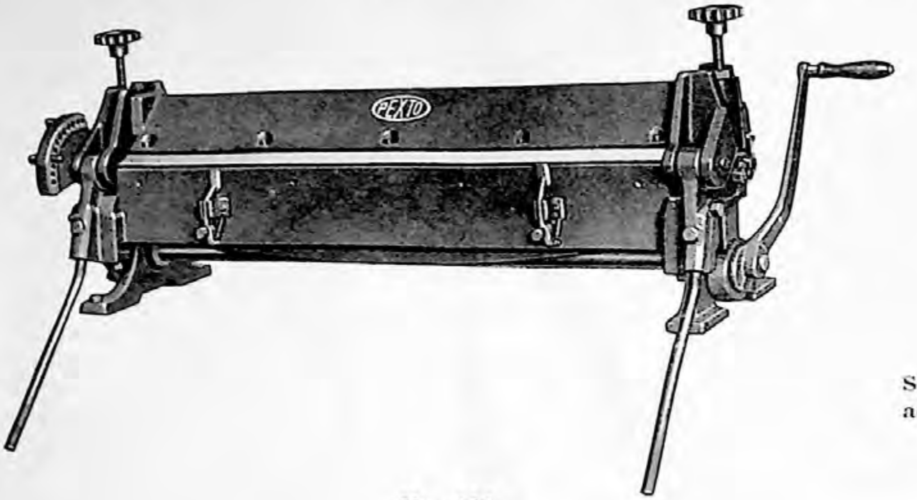
A wide range of locks and angles for which a large Brake is usually employed can be formed more conveniently on the Single Motion Utility Brake and Folder with folding blade and inserts as shown in Drawing No. 1.

Facilities for gauging are provided on the bending leaf as well as in the rear of the machine.

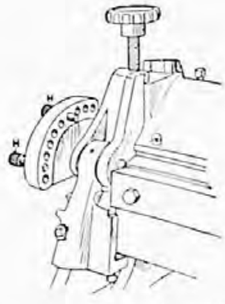
The bending leaf is provided with an adjustable handle bar for short or long leverage.

With special blades and inserts the conventional so-called Acme and Security Locks for knock-down stove pipe can be produced on this machine and which will be recommended on receipt of information pertaining to gauge of sheets and production expected.

COMBINATION FOLDER AND BRAKE

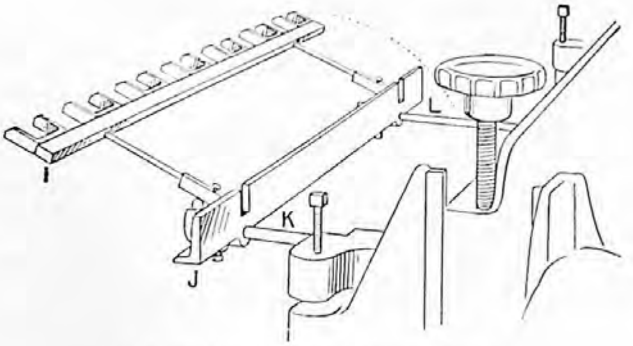


No. 696



Stop Feature—The pins (H) can be adjusted to stop the folding bar for any desired angle

When gauging for narrow bends, the gauge (I) is used. Gauging for wide bends is accomplished with gauge (J). When the gauge (J) is being used the gauge (I) swings out of the way. Both gauges slide together on the gauge supporting rods (K) and (L) and are adjustable from 1/4 to 10 inches. Front gauges fitted to folding bar are adjustable from 7/16 to 3/4 inches.



Two-in-One Purpose Rear Gauge

Number	696	697	698
Length for sheets ....ins.	36	42	60
Capacity soft steel, used as Brake for wide bends ... gauge	20	20	22
Capacity when used as Folder for narrow bending minimum 5/16" on soft steel ....gauge	20	20	22
Capacity when used as Folder for narrow bending minimum 3/16" on soft steel ....gauge	24	24	26
Shipped crated regularly ....weight approx. lbs.	430	500	700

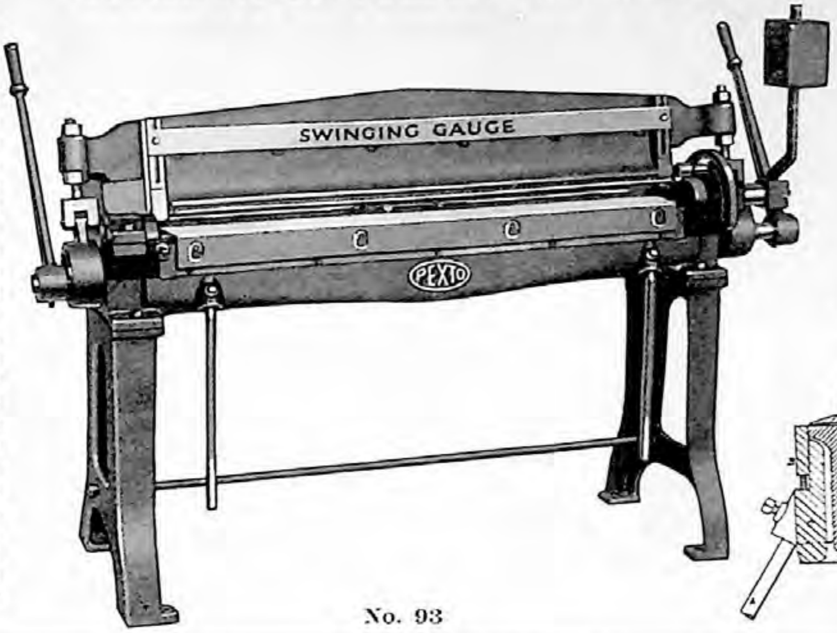
NOTE:—Furnished regularly with folding blade for sharp or closed locks and adjustable front and rear gauges. Special blades for wire locks can be furnished at extra cost. Floor legs can be furnished at extra cost.

With these machines a variety of folding operations can be produced similar to those illustrated on page 43. Like the regular Floor Brake, the jaws allow for the forming of any size of angle, the sheet remaining stationary while the folding takes place. It will form edges for lock seams with accuracy. Fitted with adjustable gauges, the scribing of sheets before each bend is not necessary.

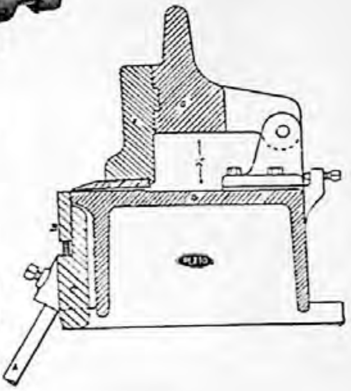
The clamping bar can be adjusted for great clearance above the bed from 1 to 3 inches. This is effected by turning knobs. By turning the crank the bar is lowered 1 inch. The sheet placed between the jaws to be edged or folded is securely clamped with a turn of crank. The folding bar is of solid steel and so proportioned that its upper edge is only ⅜-inch wide for permitting the forming of very narrow locks and angles. It is adjustable up and down for forming open locks for wiring with not more than ¼-inch radius, but a special folding blade to substitute for blade, as fitted regularly, for sharp locks, is recommended in order to secure the best results. Folding blade can be readily removed to allow substituting others of different shapes.

COMBINATION FOLDER AND BRAKE

Like the ordinary Brake it is open from front to back. The only Brake of its kind that offers an advantageous opening between the clamping bar and the bed of 3¼ inches when clamped with reference to the end view it will be seen that holder (F) to which blade (E) is attached is fastened to cross head (G) and are interchangeable for shorter sections for box and pan work. It is fitted with quadrant gauge for accurate angle forming and is also provided with a swinging gauge for gauging width of locks or angles to be formed. Clamping of the sheet is affected by means of eccentrics and through hand levers at either end of machines.



No. 93



Number	93
Length ....ins.	42
Capacity soft steel on wide angles ....gauge	16
Clamping jaws open ....ins.	1¾
Will form wide flanges or angles, locks width....ins.	⅛ to 1¾ as follows
Will form wide flanges or angles, locks width....ins.	½ to 1¾ on 16 gauge iron
Will form wide flanges or angles, locks width....ins.	3/16 to ⅜ on 18 gauge iron
Will form wide flanges or angles, locks width....ins.	¼ on 20 gauge iron
Will form wide flanges or angles, locks width....ins.	3/16 on 22 gauge iron
Will form wide flanges or angles, locks width....ins.	⅛ on 24 gauge iron
Shipped crated regularly ....weight approx. lbs.	950

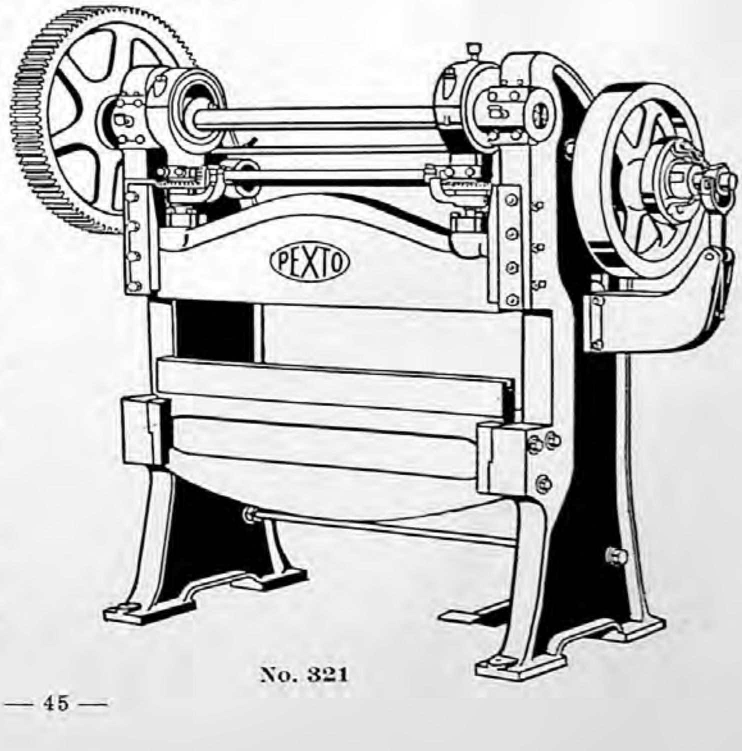
NOTE:—Can be furnished with seven formers for making circular and semi-circular bends in cornice work, etc., viz.: 3, 2½, 2, 1¾, 1½, 1¼ and 1 inch, but same are not included with regular equipment.

POWER PRESS BRAKE

Cap'y—Nos. 321-322, ½" wide bend No. 18 ga. soft steel and lighter
Nos. 323-324, ½" wide bend No. 18 ga. soft steel and lighter

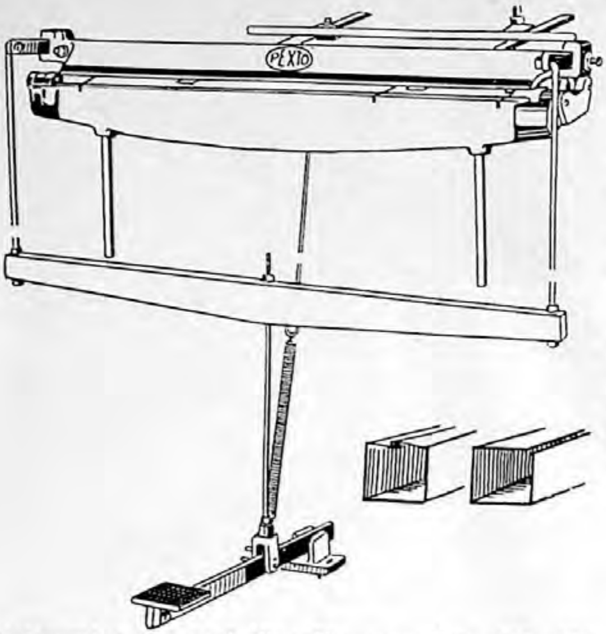
Number	321	322	323	324
Distance between uprights . ins.	39	51	63	75
Dia. shaft in bearings ....ins.	2 15/16	2 13/16	2 13/16	2 15/16
Gap in housing center of slide to frame ....ins.	2	2	2	2
Distance bed to slide stroke down adjustment up ....ins.	9½	9½	9½	9½
Stroke of slide standard...ins.	3	3	3	3
Adjustment of slide ....ins.	1½	1½	1½	1½
Height of filler piece......ins.	4½	4½	4½	4½
Area bed, F to B, R to L..ins.	2⅞x39	2⅞x51	2⅞x63	2⅞x75
Size of flywheel ....ins.	26x6	26x6	26x6	26x6
Weight of flywheel ....lbs.	325	325	325	325
Speed of flywheel ....RPM	210	210	210	210
Ratio of gearing	7:1	7:1	7:1	7:1
Horse power required	2	2	3	3
Speed of motor...........RPM	1200	1200	1200	1200
Weight on skids ..approx. lbs.	3400	3800	4200	4600

These machines are intended for straight bending operations, single right angle or acute angle bends. On large production where many pieces of the same kind are formed a Brake of this design may be preferred. The bed is provided with a removable filler piece or riser in order to take care of dies for different varieties of work. Driven from flywheel through a foot operated friction clutch, which will automatically disengage when foot is removed from treadle. Dies can be made to suit requirements.



No. 321

PIPE, BOX AND PAN FORMERS



Rectangular Box and Pipe Formers Nos. 433, 434

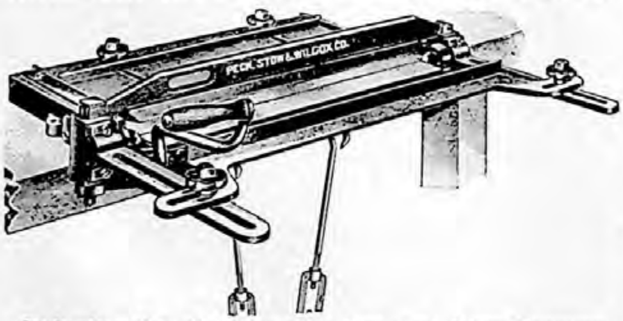
Capacity — No. 26 gauge soft steel and lighter

Number	433	434
Length for work ....width ins.	30	36
Smallest square pipe that can be formed ....ins.	3	4
Shipped boxed regularly .... weight approx. lbs.	90	175

NOTE:—Furnished complete with gauge equipment.

A machine of simple construction for forming the bodies of square and oblong cans, heater pipe, boxes, etc., with either lapped or locked side seams. A depression of the foot treadle clamps the material. The folding bar is brought up and the bend made. The work forms around the clamping bar. Sheets can be formed at right angles or less.

All parts are smoothly and accurately machined and finished.



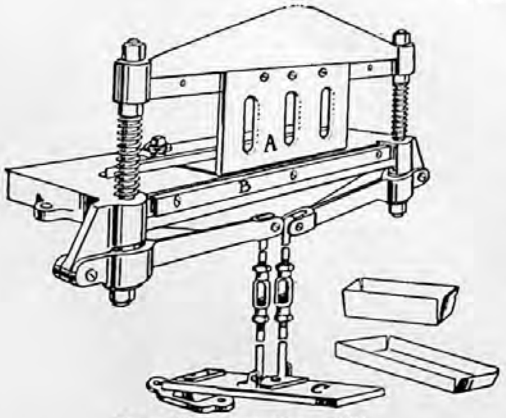
Swinging Bar Rectangular Box and Pipe Formers Nos. 438, 439

Capacity No. 24 gauge soft steel and lighter

Number	439	438
Length ....ins.	30½	36
Size of clamping bar ....ins.	2½x2¾	2¾x3½
Smallest square pipe that can be formed ....ins.	3	3¾
Width bed plate ....ins.	15	15
Shipped boxed ....approx. lbs.	135	225

These machines are well adapted for forming heater pipe, boxes, etc. A depression of the foot treadle clamps the material when the folding bar is brought up and the bend made. The work forms around the clamping bar and slips out easily for permitting the removal of the formed work without distortion. Sheets can be formed at right angles or less.

PAN FORMING MACHINE



Pan Former No. 436

Furnished regularly with forming die (B) and one blade (A) length 13½ inches for forming 90° bends. Blades of special lengths and the following standard blades are extra.

Standard Steel Forming Blades

Length, ins. 8, 10, 12, 14, 16, 18, 20, 22, 25

Capacity — No. 24 gauge soft steel and lighter

Number	436
Length die bed ....ins.	25
Width bed plate ....ins.	11½
Stroke ....ins.	¾
Shipped boxed regularly ....weight approx. lbs.	225

This machine is especially designed for forming the four sides of blanks for square or irregular shaped boxes, pans, etc., one end at a time.

Corners of blanks are notched or cut out with Notching Machine or Hand Shears. The notched blank is placed in machine between V-shaped forming blade (A) and die bed (B) and formed into proper shape by depressing foot treadle (C).

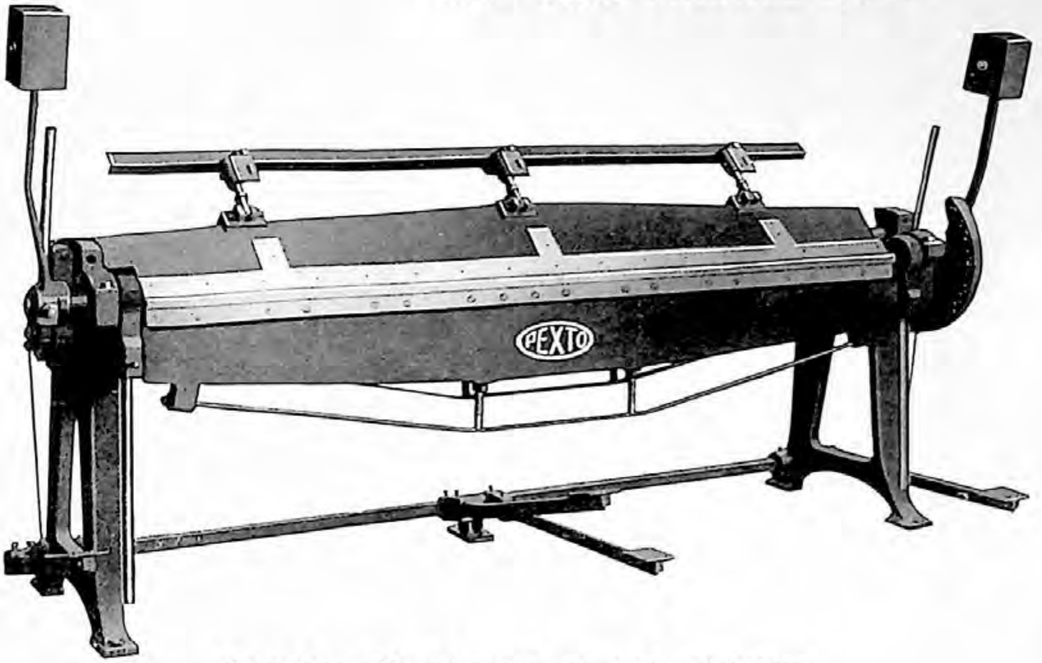
This machine is adapted for forming flaring and straight work, but variations in the flare of pans, etc., necessitates an extra forming blade and die bed.

For each size of pan or box an extra forming blade is required.

Work can be formed as shallow as ½-inch and as deep as 5½ inches. Length of die bed is 25 inches, but the length of work that can be formed depends on the depth.

With special blades and die bed, a variety of bending operations can be performed.

IRON KING CORNICE BRAKE



Capacity — No. 18 gauge soft steel and lighter

Minimum angle that can be formed on No. 18 gauge is ½ inch. Smaller angles are possible in proportion to lighter gauges of steel used.

Number		K-683	K-684	K-695
Length for Sheets	width inches	52	72	96
Clamping Jaws Open	inches	1	1	1
Shipped regularly on skids	weight approx. lbs.	1270	2350	3100

NOTE — Furnished regularly with Fourth Leaf or Automatic Forming Attachment and where not required, specify without this attachment. Accompanied regularly with one forcing bar and seven formers for making semi-circular and circular bends; viz.: 1, 1¼, 1½, 1¾, 2, 2½, 3 inches. WHERE SPECIFICATIONS DO NOT ACCOMPANY ORDERS SHIPMENT WILL BE MADE COMPLETE WITH FOURTH LEAF ATTACHMENT.

Aside from the circular forming feature that these Brakes contain as illustrated, the treadle arrangement for raising and lowering the top clamping leaf offers a very desirable addition.

The clamping bar in this Brake has been designed with a view to making it as low as consistent with its capacity for more conveniently forming ogee gutters, cornices and members in heating and ventilating work. It can be raised and lowered by treadles or eccentric levers.

When clamping jaws are closed a 2 inch rear clearance is provided. Steel blade on the bending leaf is $\frac{1}{16}$ inch wide to make possible the forming of narrow locks and reverse bends.

Fig. 1 illustrates the sheet as it is clamped between the jaws of the Brake in the usual way and the proper adjusting and setting of the fourth leaf or automatic forming attachment.

On raising the bending leaf Fig. 2 illustrates the ease in which circular bends are made.

Fig. 3 shows the fourth leaf or automatic forming attachment thrown back and the forms detached from the bending leaf when the Brake is ready for such ordinary work for which Brakes are commonly employed; viz.: square bending and the forming of locks and angles. This attachment can be omitted if not required.

FIG. 1.

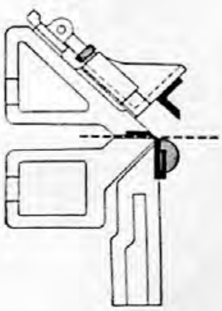


FIG. 2.

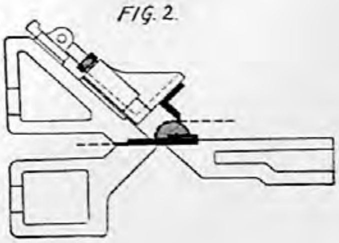
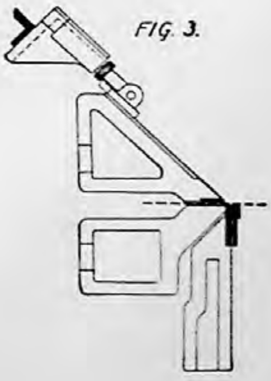
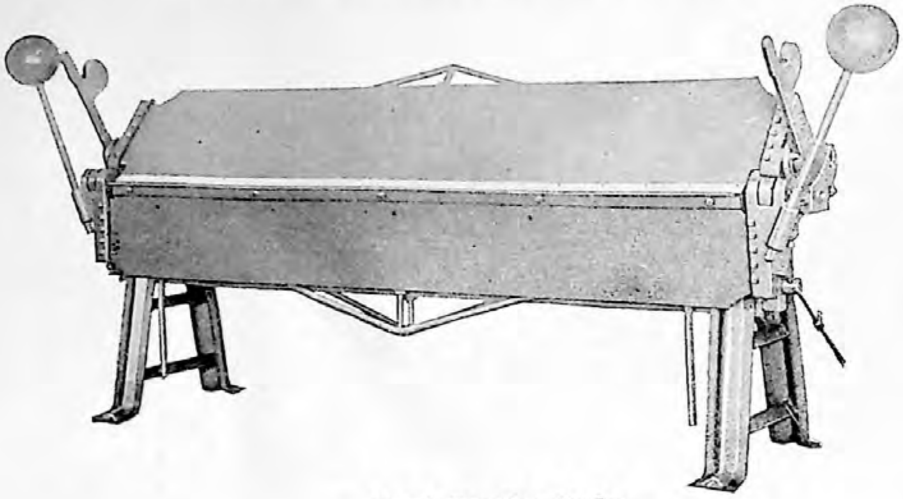


FIG. 3.



CHICAGO STEEL BENDING BRAKES



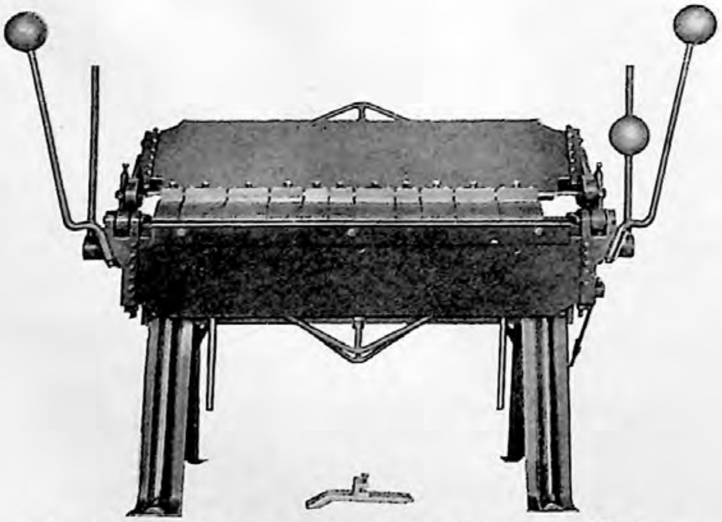
Hand Bending Brake

HAND BENDING BRAKE SIZES

Number	Length	Capacity Soft Steel	Shipping Weight, Lbs.
1109	3 ft. ½ in.	12 gauge	940
1009	3 ft. ½ in.	14 gauge	690
1004	3 ft. ½ in.	16 gauge	470
1110	4 ft. ½ in.	12 gauge	1250
1010	4 ft. ½ in.	14 gauge	810
1005	4 ft. ½ in.	16 gauge	585
1102	5 ft. 1 in.	12 gauge	1480
1101	5 ft. 1 in.	14 gauge	1230
1100	5 ft. 1 in.	16 gauge	1010
1000	5 ft. 1 in.	18 gauge	710
1107	6 ft. 1 in.	12 gauge	2015
1106	6 ft. 1 in.	14 gauge	1625

HAND BENDING BRAKE SIZES

Number	Length	Capacity Soft Steel	Shipping Weight, Lbs.
1006	6 ft. 1 in.	16 gauge	1135
1001	6 ft. 1 in.	18 gauge	820
1112	8 ft. 1 in.	12 gauge	2570
1011	8 ft. 1 in.	14 gauge	2050
1007	8 ft. 1 in.	16 gauge	1470
1002	8 ft. 1 in.	18 gauge	1010
1012	10 ft. 1 in.	14 gauge	3025
1008	10 ft. 1 in.	16 gauge	2440
1003	10 ft. 1 in.	18 gauge	2040
1103	12 ft. 1 in.	18 gauge	4275
1104	12 ft. 1 in.	22 gauge	2745



Hand Box and Pan Brake with Removable Fingers

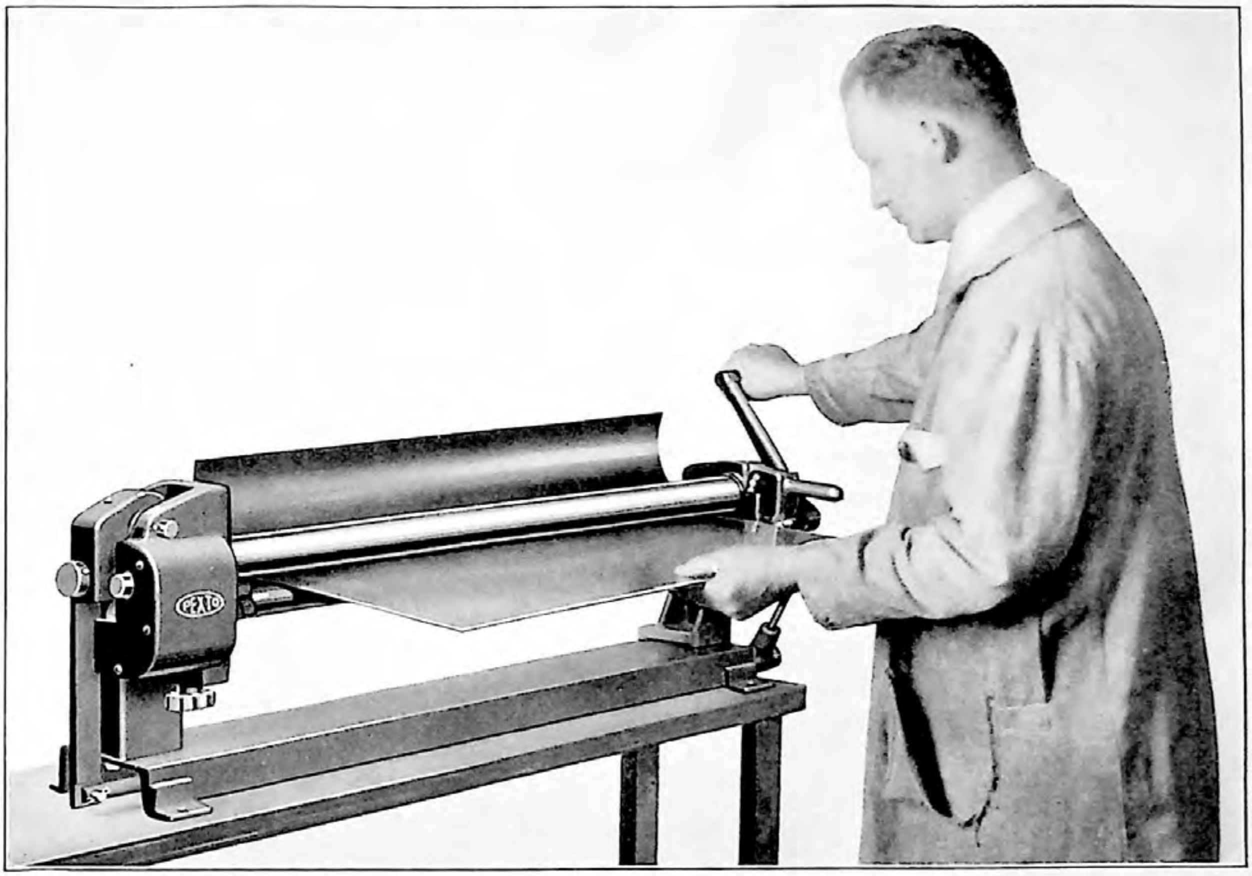
HAND BOX AND PAN BRAKE SIZES

Number	Length	Capacity Soft Steel	Finger Extension	Shipping Wgt., Lbs.
3000	3 ft.	14 gauge	6 in.	860
3001	4 ft.	14 gauge	6 in.	1150
3002	5 ft.	14 gauge	6 in.	1720
3003	3 ft.	14 gauge	8 in.	970
3004	4 ft.	14 gauge	8 in.	1500
3005	5 ft.	14 gauge	8 in.	1795
3006	6 ft.	16 gauge	6 in.	1940
3007	8 ft.	16 gauge	6 in.	2520
3008	10 ft.	18 gauge	6 in.	2925
3009	6 ft.	16 gauge	8 in.	2350
3010	8 ft.	18 gauge	8 in.	2685

All sizes of Hand Brakes listed above are furnished with ¼ inch detachable steel bar for apron and angle bar for heavy bending. Five clamps and molding formers are included, one each ⅝, 1, 1⅝, 2¼, 3 inches. The rated capacity is for mild sheet steel and for bending a flange of one inch or wider on full width sheets. Narrower flanges can be put on lighter or softer materials but not on full length sheets of maximum rated capacity.

Bulletin I-35

FORMING MACHINES



Efficiency is considerably increased through the employment of the modern machinery offered in these pages.

They are produced by an organization with a background of over one hundred years of persistent effort of serving the industry with reliable tools and machines for the fabrication of sheet metals.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

FORMING MACHINE USES

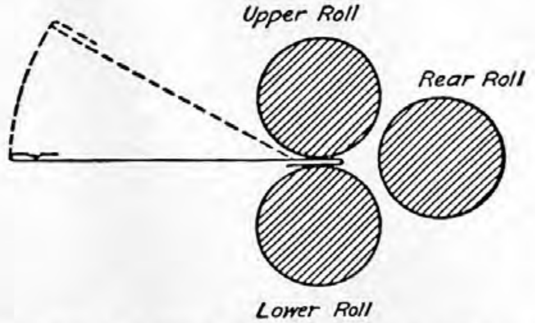
Forming Machines or Forming Rolls are extensively employed to roll sheets to cylindrical form.

FORMING MACHINES WITH SOLID HOUSINGS

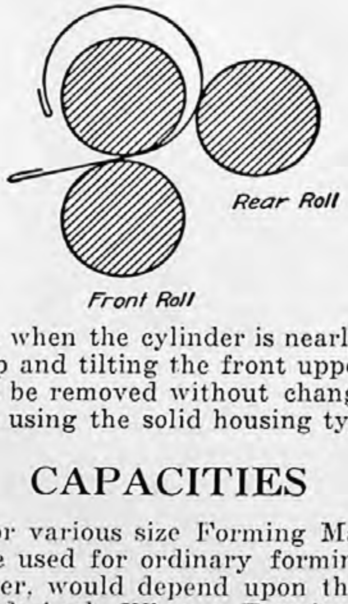
The first Formers were introduced with solid housings. The PEXTO line now offers only one pattern of solid housing Forming Machine with 2 inch rolls which is destined to go into discard as the slip roll type of Forming Machine becomes even more popular.

SLIP ROLL FORMERS

Slip roll type Forming Machines on which we are standardizing have a hinged housing for removal of formed cylinders. All the good features as claimed for PEXTO Slip Roll Forming Machine design are brought out in the descriptive pages. The lift type of Slip Roll as the PEXTO line offers is preferable — (1) for free driving, (2) for extreme clearance between rolls when removing the work, (3) elimination of any weak over-hung parts, (4) a fully-enclosed housing for the upper roll.



Cylinders are formed by inserting the sheet between the gripping rolls as shown in the above illustration.



This illustrates position of the sheet when the cylinder is nearly formed. On the Slip Roll Forming Machine, by releasing the hinged cap and tilting the front upper gripping roll through means of a hand lever, the finished cylinder can be removed without changing its shape as would happen in springing the work from rolls when using the solid housing type of Former.

CAPACITIES

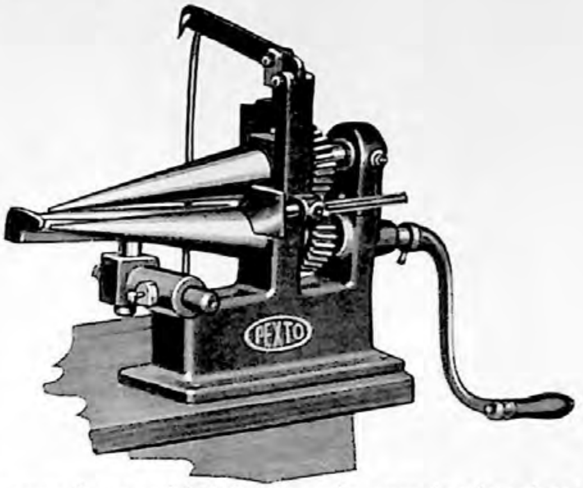
The capacity ratings herein listed for various size Forming Machines are considered as standard by the sheet metal trade and can be used for ordinary forming where extreme accuracy is not required. Definite capacities, however, would depend upon the diameter and length of cylinder, stiffness of material and uniformity desired. When a Forming Machine is overloaded the immediate result will be deflection in the center of the rolls, resulting in cylinders bilged in the center. In selecting suitable machine for work contemplated, accuracy required in the finished product must be taken into consideration.

If in doubt as to machine required for your work, we would suggest you advise us gauge and kind of material to be used, maximum length and minimum diameter of cylinder to be formed.

FUNNEL FORMER

Number 459

Capacity — No. 26 gauge soft steel and lighter



Length of forming rolls ....ins.	10
Smallest diameter that can be formed on small end ....ins.	⅝
Smallest diameter that can be formed on large end ....ins.	3
Shipped boxed ....approx. lbs.	95

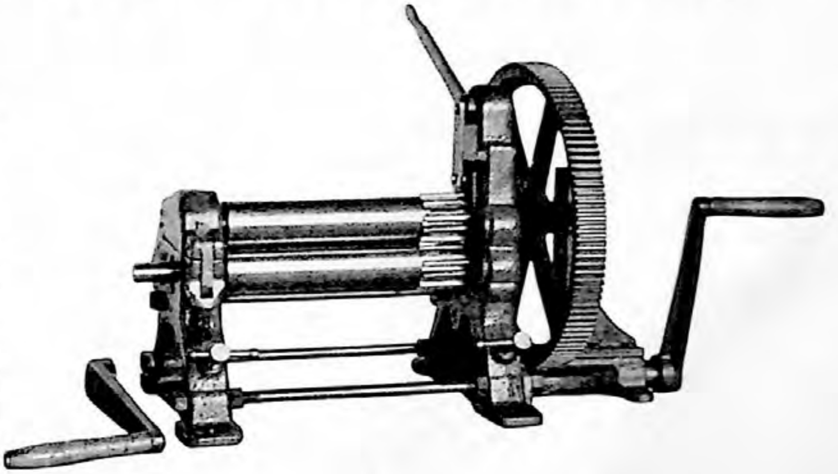
Intended for forming conical and taper work of various angles such as can tops, funnels, lamp shades, etc. The third, or forming roll, not shown in cut is adjustable to all positions. The upper roll is depressed by means of foot treadle and can be adjusted for different thicknesses of material. An adjustable gauge is provided for forming work of various lengths.

SHORT HEAVY SLIP ROLL FORMING MACHINE

Number 414

SINGLE BACK GEARED

Capacity — ⅛ inch soft steel and lighter

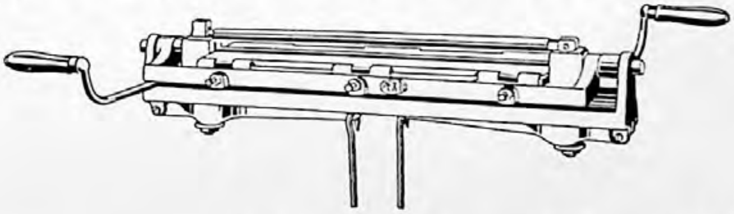


Length of rolls for sheets width ....ins.	12
Diameter of rolls ....ins.	3
Ratio of gearing ....ins.	10 to 1
Shipped crated approx. lbs.	425

An extra heavy short Former designed for heavy duty. It is of the slip roll type. The lifting of the upper roll is effected through a hand lever.

TUBE FORMERS

With Swinging Mandrels for Lap or Lock Seam Tubes

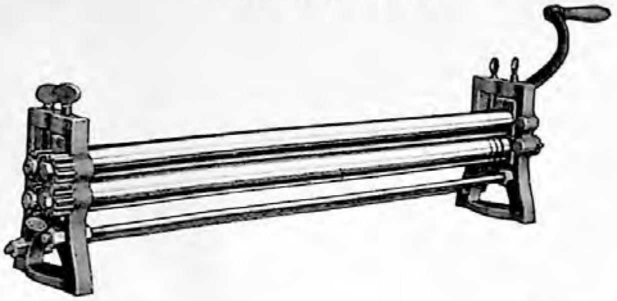


Number	**450**	**451**	**452**	**453**	**454**	**455**
Shipping weight ....approx. lbs.	130	115	108	95	80	75
Length of forming mandrel ....ins.	24	20	15½	11½	8½	5½
Can be constructed to form tubes from ....ins.	⅝ to 2	⅝ to 2	⅝ to 2	½ to 1¾	½ to 1¾	½ to 1¾

Capacity depends upon diameter and length of tube. When making inquiry state full particulars or send sample of tube of same material to be used.

COMPENSATING GEAR FORMERS

SOLID HOUSINGS



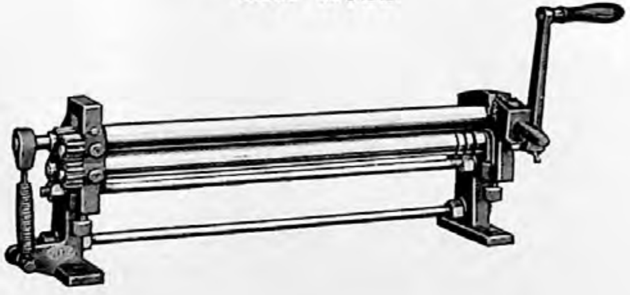
Number		373	372	0372
Length of rolls for sheets	width ins.	30	36	42
Capacity, soft steel	gauge No.	22	22	24
Diameter of rolls	ins.	2	2	2
Shipped boxed	approx. lbs.	140	160	175

NOTE:—Grooves cut in rolls are intended to allow work with a wire to be formed. Wire should only be formed between the grooves cut for that purpose.

A very desirable inexpensive forming roll for all work where a solid housing Former is preferable. They have solid housings and are fitted with machine cut steel compensating gears. Gears to run smoothly should mesh constantly to a certain depth. In these Formers the gears on the gripping rolls do not mesh with each other, but with two extra gears fitted to the frame. When the gripping rolls are moved the mesh of the gearing is unchanged. This insures uniformity of action and durability for the gears, they running more smoothly than cast iron cogs, without danger of slipping or breaking with whatever thickness of metal is used.

TIN PIPE FORMERS

SLIP ROLL



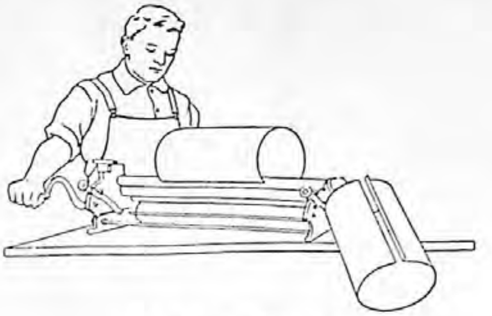
Number		0350	0384
Length of rolls for sheets	width ins.	16	20
Diameter of rolls	ins.	1	1½
Shipped boxed	approx. lbs.	45	90

These Formers are intended for forming cylinders of small diameters and are an improvement over our old Slip Roll Tin Pipe Forming Machines and those which the present market offers. All operations are performed at one end of the machine — the convenient end, where the crank is fitted.

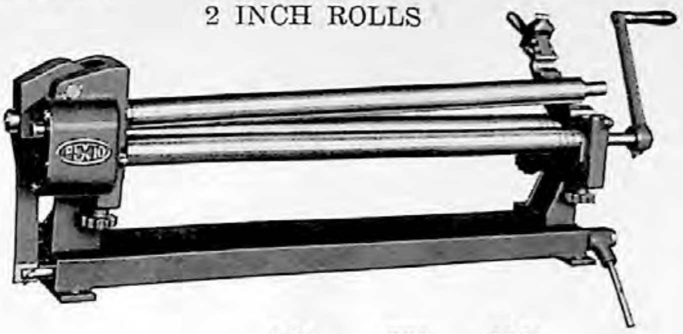
After the cylinder is formed the latch when opened permits the upper roll to raise automatically. The formed cylinder can then be removed from the roll without distorting it. The Latch with the roll is released and closed with one movement and is self-locking. Rolls are adjusted with knurled screws and once adjusted they cannot slip. The gears are steel, machine cut.

IMPROVED LIGHTNING SLIP ROLL FORMING MACHINES

(PATENTED)



2 INCH ROLLS



Number—Hand drive	**382**	**381**	**0381**
Number—Tight pulley drive	**1382**	**1381**	**10381**
*Capacity soft steel ....ga.	22	22	24
Length of rolls for sheets ....width ins.	30	36	42
Diameter of rolls ....ins.	2	2	2
Speed of rolls, pulley drive ....r.p.m.	75	75	75
Size of pulleys ....ins.	12x2½	12x2½	12x2½
Shipped boxed, hand........approx. lbs.	220	245	270
Shipped boxed, power ....approx. lbs.	260	275	310

NOTE:—Floor legs can be furnished at extra cost. Can be arranged with belted motor drive attachment mounted on floor legs at extra cost. Upper and lower rolls are driven. At an extra cost all three rolls can be arranged driven.

The lift type of Slip Roll Former, as these new patterns offer, leaves free the hands of the operator for the feeding and removal of work. Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on right end of machine always in easy reach of operator and locks automatically with the roll in tilted position. Simple and very easy to operate.

The rolls need not be stopped when operating the lifting device, a desirable feature especially when arranged power drive, an improvement that merits consideration. Rolls are high carbon steel, smoothly finished and ground.

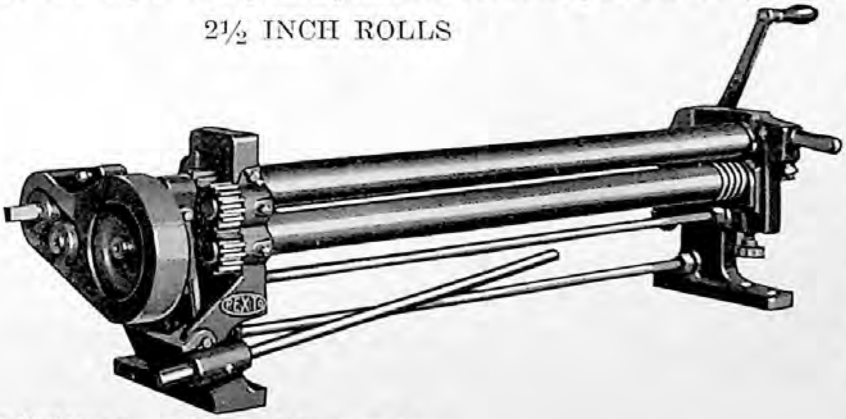
Strength is assured through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped, it serves as a desirable support making a fully enclosed housing for the upper roll.

The compensating gears are solid steel machine cut always remaining in mesh and are fully enclosed. This permits for ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets. Positively no binding of gears while machine is run with upper roll in horizontal or in tilted position.

Housings are rigidly mounted on steel base. Rolls are ground and smoothly finished and are provided with a series of grooves for forming work that has been previously wired.

External grease cups are provided for idler gears in the gear case.

2½ INCH ROLLS



Number	**390**	**391**
*Capacity gauge No.	16 - 18	18 - 20
Length of roll for sheets ......width ins.	36	42
Diameter rolls......ins.	2½	2½
Ratio of gearing	2 to 1	2 to 1
Shipped boxed regularly approx. lbs.	360	400

NOTE: — The two front rolls are driven. At an extra cost all three rolls can be arranged driven.

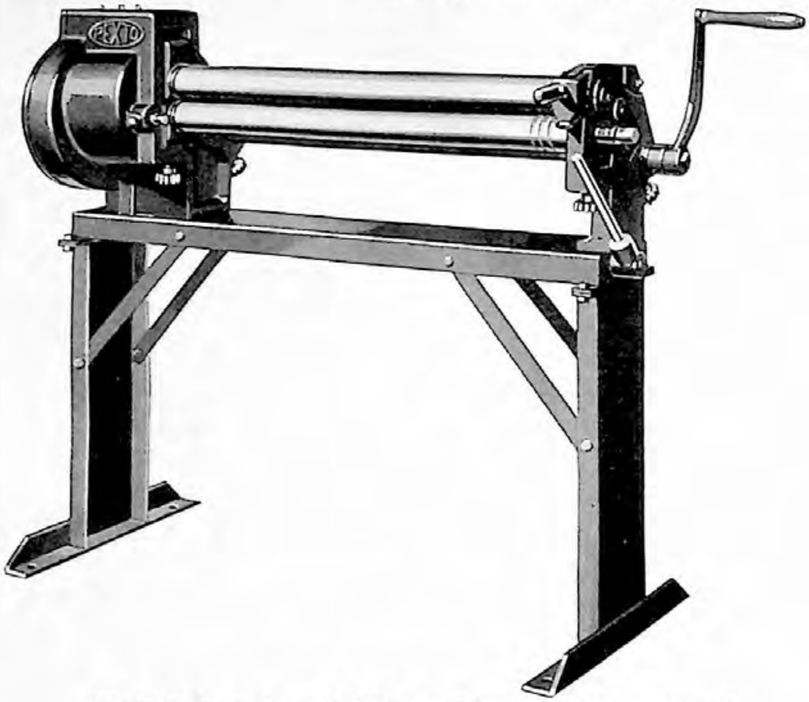
* Reference—"Capacities" Page 50.

IMPROVED LIGHTNING SLIP ROLL FORMING MACHINES

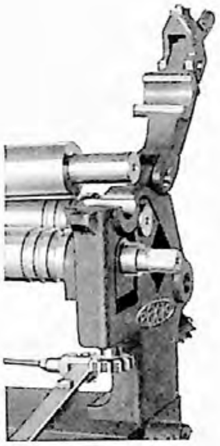
3 INCH ROLLS

Arranged for Hand, T. and L. Pulleys, or Double Friction Clutch Belt or Motor Drive

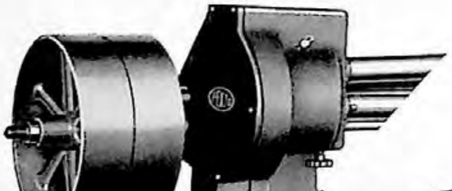
For specifications see pages 55-56



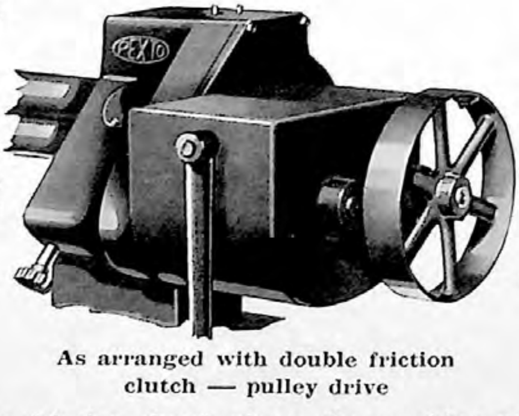
Slip Roll Forming Machine — 3 inch rolls as arranged hand drive mounted on floor legs



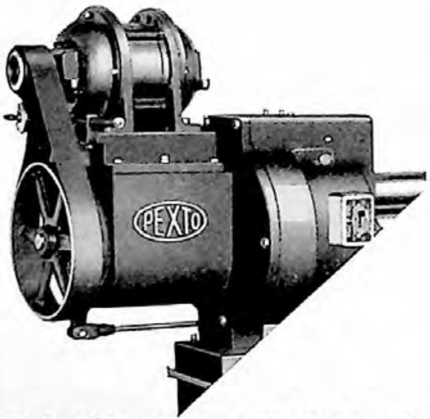
Hinge cap construction



Slip Roll Forming Machine — 3 inch rolls as arranged with T. and L. pulleys



As arranged with double friction clutch — pulley drive



3 inch rolls as arranged with double friction clutch and belted motor drive attachment

This application of double friction clutch places the machine under full control of the operator. The clutch is controlled through a lever that locks automatically in three positions — forward, neutral and reverse. Furnished pulley drive to be belted from line shaft or individual belted motor drive as illustrated.

IMPROVED LIGHTNING

SLIP ROLL FORMING MACHINES

(PATENTED)

3 INCH ROLLS

Arranged for Hand or T. and L. Pulleys

See illustration page 54

Number—Hand drive	**416**	**417**	**418**
Number—T. and L. pulley drive	**0416**	**0417**	**0418**
Length of rolls for sheets.....width ins.	36	42	48
*Capacity for soft steel.....ga.	14-16	15-18	16-18
Diameter of rolls.....ins.	3	3	3
Ratio of gearing.....	4:1	4:1	4:1
Size of drive pulleys.....ins.	18x4	18x4	18x4
Speed of drive pulleys.....r.p.m.	200	200	200
Speed of rolls.....r.p.m.	50	50	50
Shipped crated—hand operated.....approx. lbs.	815	875	940
Shipped crated—T. and L. pulley.....approx. lbs.	850	910	975

NOTE:—When furnished hand drive floor legs are not included but can be fitted at an extra cost when specified. When ordered with T. and L. pulleys, floor legs are included unless order specifies that floor legs are to be omitted. When required for power drive through double friction clutch, order from page 56. Adjustment of rolls is effected through hand wheels. Sprocket chain for adjustment of rear forming roll can be applied at extra cost.

In this new type of Slip Roll Forming Machine all three rolls are driven and the rear forming roll has three longitudinal grooves.

All gears are machine cut and fully enclosed. The driving pinions are steel and the large driving gear is semi-steel.

The lift type of Slip Roll Former, as these new patterns offer, leave free the hands of the operator for the feeding and removal of work.

Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on right end of machine always within easy reach of operator and locks automatically with the roll in tilted position. Simple and very easy to operate.

The rolls need not be stopped when operating the lifting device, a desirable feature especially when arranged power drive, an improvement that merits consideration. Rolls are high carbon steel, smoothly finished and ground.

Any weak over-hung parts are eliminated through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped, it serves as a desirable support making a fully enclosed housing for the upper roll.

The compensating gears always remain in mesh. This permits for ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets. Positively no binding of gears while machine is run with upper roll clamped or in tilted position.

Housings are rigidly mounted on steel base. Rolls are high carbon steel smoothly ground and finished and are provided with a series of grooves for forming work that has been previously wired.

* Reference—"Capacities" Page 50.

IMPROVED LIGHTNING POWER SLIP ROLL FORMING MACHINES

3 INCH ROLLS

With Double Friction Clutch

See illustration page 54

Number—Pulley drive with double friction clutch	**1416**	**1417**	**1418**
Number—Belted motor drive with double friction clutch	**2416**	**2417**	**2418**
Length of rolls for sheets ....ins.	36	42	48
*Capacity for soft steel ....ga.	14-16	15-18	16-18
Diameter of rolls ....ins.	3	3	3
Ratio of gearing	10:1	10:1	10:1
Speed of rolls ....r.p.m.	50	50	50
Speed of drive pulleys ....r.p.m.	500	500	500
Size of drive pulleys ....ins.	12x2	12x2	12x2
Motor required ....h.p.	¾	¾	¾
Speed of motor ....r.p.m.	1800	1800	1800
Diameter of motor pulley ....ins.	3½	3½	3½
Floor space F-B, R-L ....ins.	24x70	24x76	24x82
Shipped crated—pulley drive ....approx. lbs.	955	1015	1080
Shipped crated—motor drive, less motor........approx. lbs.	980	1040	1105

NOTE:—Belted motor drive arrangement does not include motor, pulley for motor, belt or belt guard. Floor legs are regularly furnished with these machines but can be omitted when specified. Adjustment of rolls is effected through hand wheels. Sprocket chain for adjustment of rear forming roll can be applied at extra cost.

A new Forming Machine with double friction clutch controlled through a lever that locks automatically in three positions — forward, neutral and reverse.

All three rolls are driven and the rear roll has three longitudinal grooves.

The high-speed gears and the clutch mechanism are totally enclosed in the gear box running in oil requiring no attention. Bearings in the gear box are bronze bushed, employing alemite system for lubrication. Grease gun is furnished. A solidified oil such as alemite is recommended for best results.

The Carlisle Johnson type of clutch was selected after extensive tests proving most reliable and suitable for this type of Forming Machine.

The lift type of Slip Roll Former, as these new patterns offer, leave free the hands of the operator for the feeding and removal of work.

Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on right end of machine always within easy reach of operator and locks automatically with the roll in tilted position. Simple and very easy to operate.

The rolls need not be stopped when operating the lifting device, a desirable feature especially when arranged power drive, an improvement that merits consideration. Rolls are high carbon steel, smoothly finished and ground.

Any weak over-hung parts are eliminated through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped, it serves as a desirable support making a fully enclosed housing for the upper roll.

Gears always remain in mesh for ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets. **Positively no binding of gears while machine is run with upper roll clamped or in tilted position.**

Housings are rigidly mounted on steel base. The rolls are high carbon steel smoothly ground and finished and are provided with a series of grooves for forming work that has been previously wired.

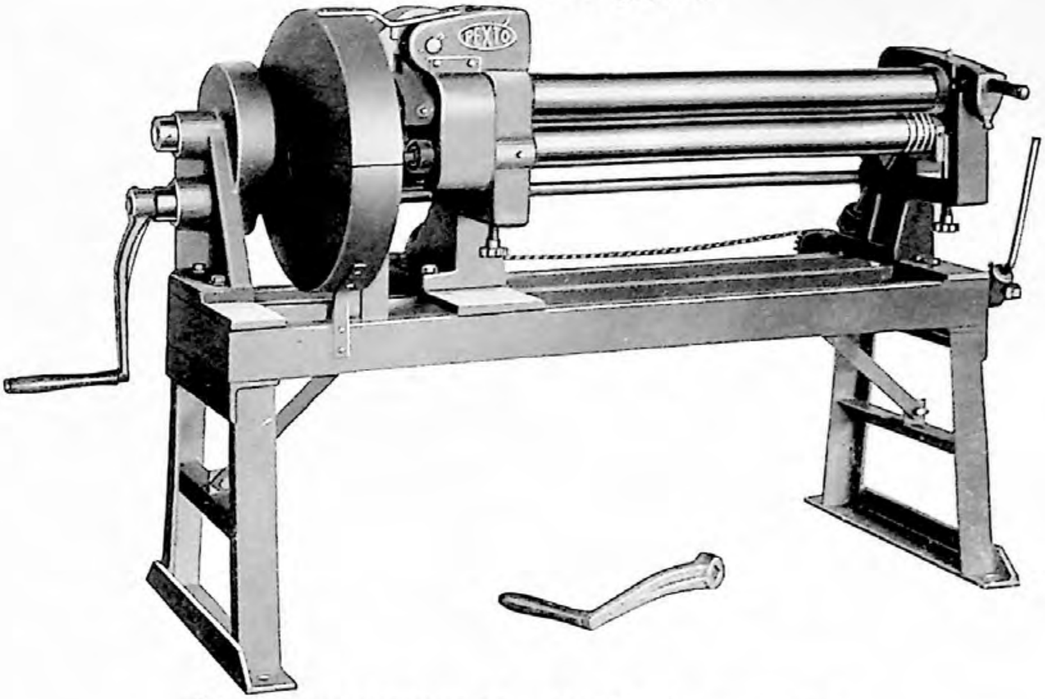
* Reference—"Capacities" Page 50.

IMPROVED LIGHTNING
SLIP ROLL FORMING MACHINES

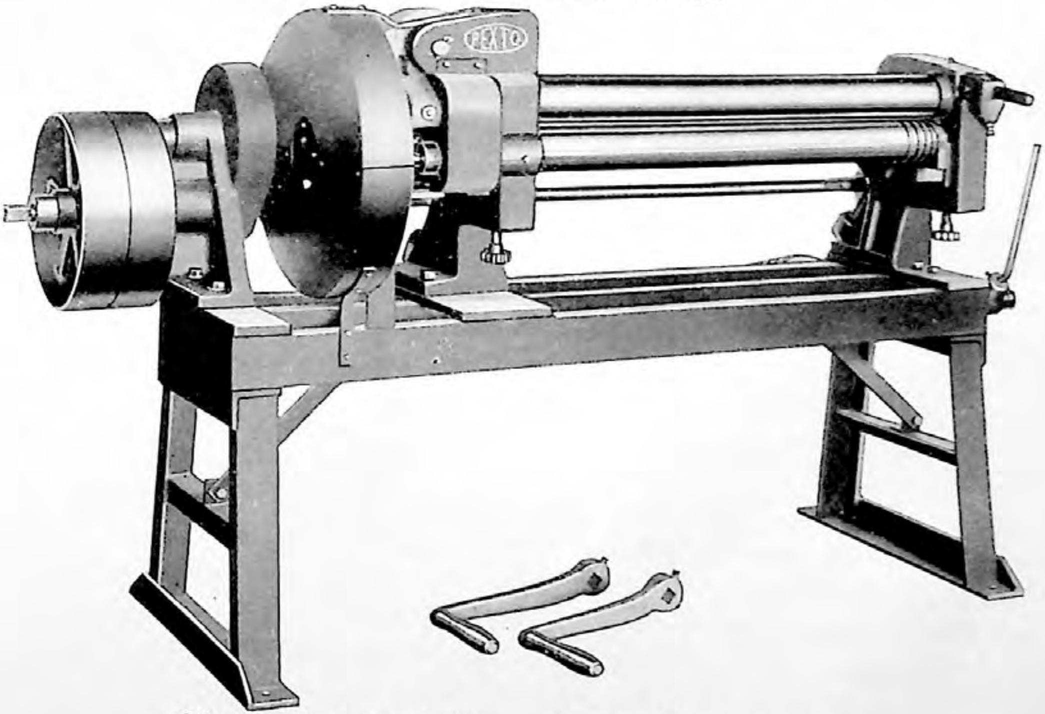
4 INCH ROLLS DOUBLE BACK GEARED

Arranged for Hand or T. and L. Pulleys

For specifications see page 58



Slip Roll Forming Machine — 4 inch rolls as arranged hand drive mounted on floor legs



Slip Roll Forming Machine — 4 inch rolls as arranged with T. and L. pulleys mounted on floor legs

IMPROVED LIGHTNING SLIP ROLL FORMING MACHINES

4 INCH ROLLS

DOUBLE BACK GEARED

Arranged for Hand or T. and L. Pulleys

See illustration page 57

Number—Hand drive	**424**	**425**	**426**	**427**	**428**	**430**
Number—T. and L. pulley drive	**0424**	**0425**	**0426**	**0427**	**0428**	**0430**
Length of rolls for sheets width ins.	36	42	48	54	60	72
*Capacity for soft steel ga.	10-12	11-13	12-14	13-15	14-16	16-18
Diameter of rolls ins.	4	4	4	4	4	4
Ratio of gearing	15:1	15:1	15:1	15:1	15:1	15:1
Speed of rolls r.p.m.	25	25	25	25	25	25
Speed of drive pulleys r.p.m.	375	375	375	375	375	375
Size of drive pulleys ins.	16x4	16x4	16x4	16x4	16x4	16x4
Floor space—hand drive ins.	40x93	40x99	40x105	40x111	40x117	40x129
Floor space—T. and L. pulley drive ins.	40x103	40x109	40x115	40x121	40x127	40x139
Shipped on skids—hand drive approx. lbs.	1700	1800	1900	2000	2100	2300
Shipped on skids—pulley drive approx. lbs.	1775	1875	1975	2075	2175	2375

NOTE:—When furnished hand drive or T. and L. pulley drive floor legs are included. When required for power drive through double friction clutch order from page 60.

Can furnish for direct geared motor drive.

A new type of Slip Roll Forming Machine of rigid construction embodying worth-while modern features for ease of operation.

All three rolls are driven and the rear forming roll has three longitudinal grooves.

Sprocket chain is provided for the convenient adjustment of the rear or forming roll.

All gears are machine cut and fully enclosed. The driving pinions are steel and the large driving gear is semi-steel.

The lift type of Slip Roll Former, as these new patterns offer, leave free the hands of the operator for the feeding and removal of work.

Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on right end of machine always within easy reach of operator and locks automatically with the roll in tilted position. Simple and very easy to operate.

The rolls need not be stopped when operating the lifting device, a desirable feature especially when arranged power drive, an improvement that merits consideration.

Any weak over-hung parts are eliminated through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped, it serves as a desirable support making a fully enclosed housing for the upper roll.

The compensating gears always remain in mesh. This permits for ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets. Positively no binding of gears while machine is run with upper roll clamped or in tilted position.

Housings are rigidly mounted on steel base. Rolls are high carbon steel smoothly ground and finished and are provided with a series of grooves for forming work that has been previously wired.

External grease cups are provided for idler gears in the gear case.

* Reference—"Capacities" Page 50.

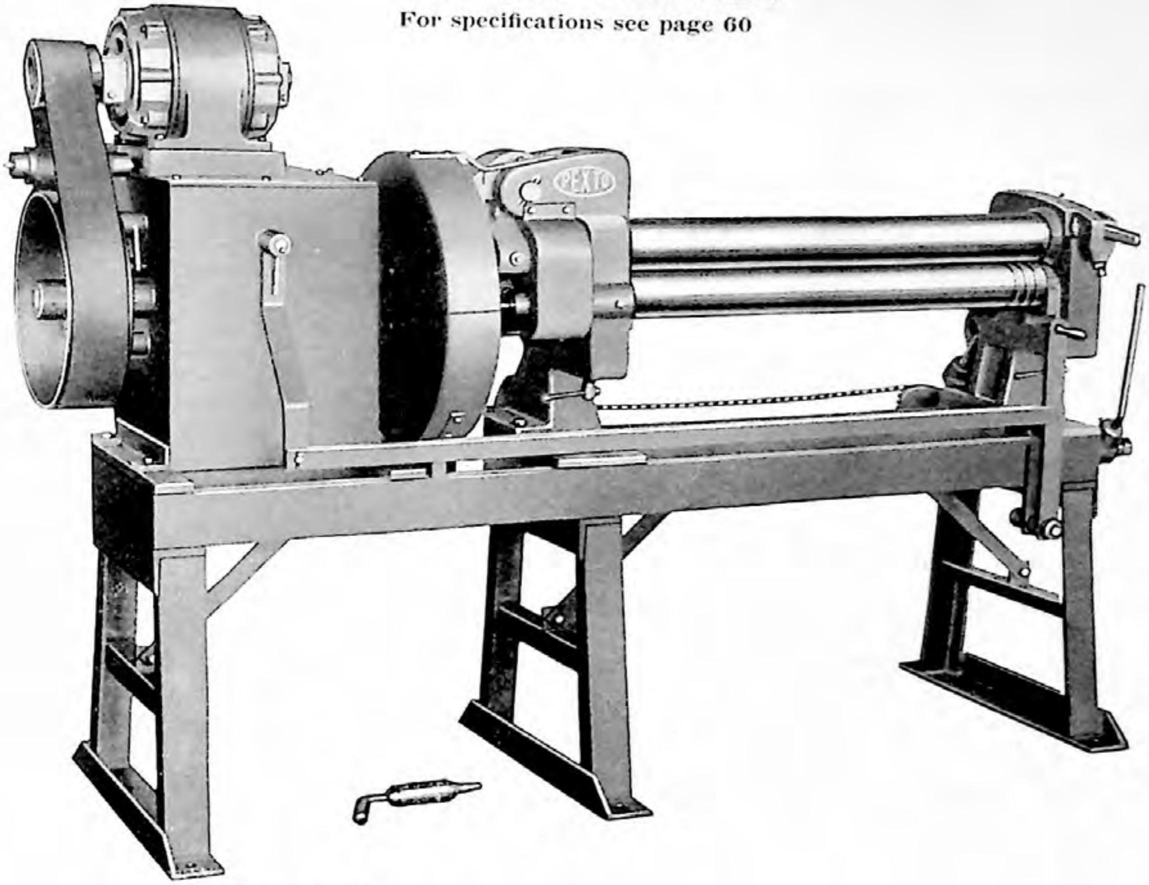
IMPROVED LIGHTNING POWER SLIP ROLL FORMING MACHINES

4 INCH ROLLS

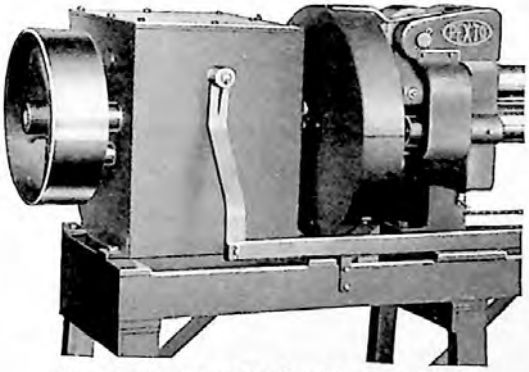
DOUBLE BACK GEARED

With Double Friction Clutch

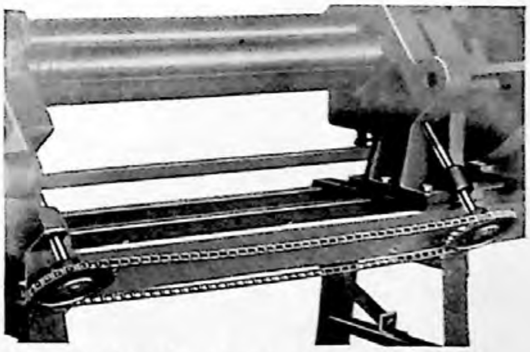
For specifications see page 60



4 inch rolls as arranged with double friction clutch and belted motor drive attachment



As arranged with double friction clutch — pulley drive



Section showing sprocket chain for adjusting rear forming roll

This application of double friction clutch places the machine under full control of the operator. The clutch is controlled through a lever that locks automatically in three positions — forward, neutral and reverse. Furnished pulley drive to be belted from line shaft or individual belted motor drive as illustrated.

IMPROVED LIGHTNING
POWER SLIP ROLL FORMING MACHINES

4 INCH ROLLS

DOUBLE BACK GEARED

With Double Friction Clutch

See illustration page 59

Number—Pulley drive with double friction clutch	**1424**	**1425**	**1426**	**1427**	**1428**	**1430**
Number—Belted motor drive with double friction clutch	**2424**	**2425**	**2426**	**2427**	**2428**	**2430**
Length of rolls ....ins.	36	42	48	54	60	72
*Capacity for soft steel ....ga.	10-12	11-13	12-14	13-15	14-16	16-18
Diameter of rolls ....ins.	4	4	4	4	4	4
Ratio of gearing	15:1	15:1	15:1	15:1	15:1	15:1
Speed of rolls ....r.p.m.	25	25	25	25	25	25
Speed of drive pulleys ....r.p.m.	375	375	375	375	375	375
Size of drive pulleys ....ins.	16x4	16x4	16x4	16x4	16x4	16x4
Motor required ....h.p.	1	1	1½	1½	2	2
Speed of motor ....r.p.m.	1200	1200	1200	1200	1200	1200
Diameter of motor pulley ....ins.	5½	5½	5½	5½	5½	5½
Floor space ....ins.	46x90	46x96	46x102	46x108	46x114	46x126
Shipped on skids, pulley drive........approx. lbs.	2200	2300	2400	2500	2600	2800
Shipped on skids, motor drive, less motor.approx. lbs.	2225	2325	2425	2525	2625	2825

NOTE:—Floor legs are regularly furnished with these machines. Belted motor drive arrangement does not include motor, pulley for motor, belt or belt guard.

A new Forming Machine meriting the consideration of manufacturers turning out any product cylindrical in shape.

The application of double friction clutch places the machine under full control of the operator. This clutch is of the Carlisle Johnson type selected after extensive tests proving most reliable and suitable for this type of Forming Machine. It is controlled through a lever that **locks automatically** in three positions — **forward, neutral and reverse.**

The lift type of Slip Roll Former, as these patterns offer, is preferable in order to gain advantage of the best principles in Forming Machine construction and operation.

The high-speed gears and the clutch mechanisms are totally enclosed in the gear box running in oil requiring no attention. Bearings in the gear box are bronze bushed, employing alemite system for lubrication. Grease gun is furnished. A solidified oil such as alemite is recommended for best results.

All gears are machine cut and fully enclosed. The driving pinions are steel and the large driving gear is semi-steel.

All three rolls are driven and the rear forming roll has three longitudinal grooves.

Sprocket chain is provided for the convenient adjustment of the rear or forming roll.

Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on the right end of machine always within easy reach of the operator and locks automatically with the roll in tilted position. The lifting mechanism operates with remarkable ease.

The rolls need not be stopped when operating the lifting device. A desirable feature as can be obtained only in this design of open end Formers.

Any weak over-hung parts are eliminated through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped it serves as a desirable support making a fully enclosed housing for the upper roll.

Gears always remain in mesh to provide ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets.

Positively no binding of gears while machine is run with upper roll clamped or in tilted position.

Housings are rigidly mounted on steel base. The rolls are high carbon steel smoothly ground and finished and are provided with a series of grooves for forming work that has been previously wired.

*** Reference—"Capacities" Page 50.**

IMPROVED LIGHTNING POWER SLIP ROLL FORMING MACHINES

4½, 5, 5½ INCH ROLLS
DOUBLE BACK GEARED

See illustrations pages 57-59

In all general appearances these machines are the same as illustrated on pages 9 and 11, but heavier in proportion. They embody all such mechanical and operating features as fully described on pages 10 and 12. Rolls 5 inch and larger do not have grooves cut in rolls for wire forming.

Rolls 4½ inches in diameter can be furnished T. and L. pulley drive without double friction clutch or pulley drive with double friction clutch or belted motor drive with double friction clutch but 5 and 5½ inch rolls are invariably furnished pulley drive with double friction clutch or belted motor drive with double friction clutch.

Our experience has shown that a reversible clutch is vitally essential for the satisfactory operation of Forming Machines with rolls 5 inches in diameter and larger.

4½ INCH ROLLS — SPECIFICATIONS

Number—T. and L. pulley drive without clutch	**404**	**405**	**406**	**407**	**469**	**470**
Number—Pulley drive with double friction clutch	**1404**	**1405**	**1406**	**1407**	**1469**	**1470**
Number—Belted motor drive with double friction clutch	**3404**	**3405**	**3406**	**3407**	**3469**	**3470**
Length of rolls for sheets ....width ins.	36	48	60	72	96	120
*Capacity for soft steel ....ga.	8-10	10-12	12-14	14-16	20-22	22-24
Diameter of rolls ....ins.	4½	4½	4½	4½	4½	4½
Ratio of gearing........	15:1	15:1	15:1	15:1	15:1	15:1
Speed of rolls ....r.p.m.	25	25	25	25	25	25
Speed of drive pulleys ....r.p.m.	375	375	375	375	375	375
Size of drive pulleys ....ins.	16x4	16x4	16x4	16x4	16x4	16x4
Motor required ....h.p.	1½	2	3	3	5	5
Speed of motor ....r.p.m.	1200	1200	1200	1200	1200	1200
Diameter of motor pulley ....ins.	5½	5½	5½	5½	5½	5½
Floor space—T. and L. pulleys ....ins.	40x103	40x115	40x127	40x139	40x163	40x187
Floor space—clutch drive ....ins.	46x90	46x102	46x114	46x126	46x150	46x174
Shipped on skids—T. and L. pulleys...approx. lbs.	1850	2050	2250	2450	2850	3250
Shipped on skids—clutch drive........approx. lbs.	2300	2500	2700	2900	3300	3700
Shipped on skids, motor drive, less motor.approx. lbs.	2325	2525	2725	2925	3325	3725

5 INCH ROLLS — SPECIFICATIONS

Number—Pulley drive with double friction clutch	**408**	**409**	**410**	**411**	**471**	**472**
Number—Belted motor drive with double friction clutch	**1408**	**1409**	**1410**	**1411**	**1471**	**1472**
Length of rolls for sheets ....width ins.	36	48	60	72	96	120
*Capacity for soft steel ....ga.	6-8	8-10	10-12	12-14	16-18	18-20
Diameter of rolls ....ins.	5	5	5	5	5	5
Ratio of gearing	15:1	15:1	15:1	15:1	15:1	15:1
Speed of rolls ....r.p.m.	18	18	18	18	18	18
Speed of drive pulleys ....r.p.m.	275	275	275	275	275	275
Size of drive pulleys ....ins.	24x5	24x5	24x5	24x5	24x5	24x5
Motor required ....h.p.	3	3	5	5	7½	7½
Speed of motor ....r.p.m.	1200	1200	1200	1200	1200	1200
Diameter of motor pulley ....ins.	6	6	6	6	6	6
Floor space ....ins.	61x105	61x107	61x129	61x141	61x165	61x189
Shipped on skids, pulley drive........approx. lbs.	3600	3800	4000	4200	4600	5000
Shipped on skids, motor drive, less motor.approx. lbs.	3650	3850	4050	4250	4650	5050

5½ INCH ROLLS — SPECIFICATIONS

Number—Pulley drive with double friction clutch	**442**	**443**	**444**	**445**	**473**	**474**
Number—Belted motor drive with double friction clutch	**1442**	**1443**	**1444**	**1445**	**1473**	**1474**
Length of rolls for sheets ....width ins.	36	48	60	72	96	120
*Capacity for soft steel ....ga.	4-6	6-8	8-10	10-12	14-16	16-18
Diameter of rolls ....ins.	5½	5½	5½	5½	5½	5½
Ratio of gearing	15:1	15:1	15:1	15:1	15:1	15:1
Speed of rolls ....r.p.m.	18	18	18	18	18	18
Speed of drive pulleys ....r.p.m.	275	275	275	275	275	275
Size of drive pulleys ....ins.	24x5	24x5	24x5	24x5	24x5	24x5
Motor required ....h.p.	3	3	5	5	7½	7½
Speed of motor ....r.p.m.	1200	1200	1200	1200	1200	1200
Diameter of motor pulley ....ins.	6	6	6	6	6	6
Floor space ....ins.	61x105	61x117	61x127	61x141	61x165	61x189
Shipped on skids, pulley drive........approx. lbs.	3750	4000	4300	4600	5150	5750
Shipped on skids, motor drive, less motor.approx. lbs.	3800	4050	4350	4650	5200	5800

* Reference—"Capacities" Page 50.

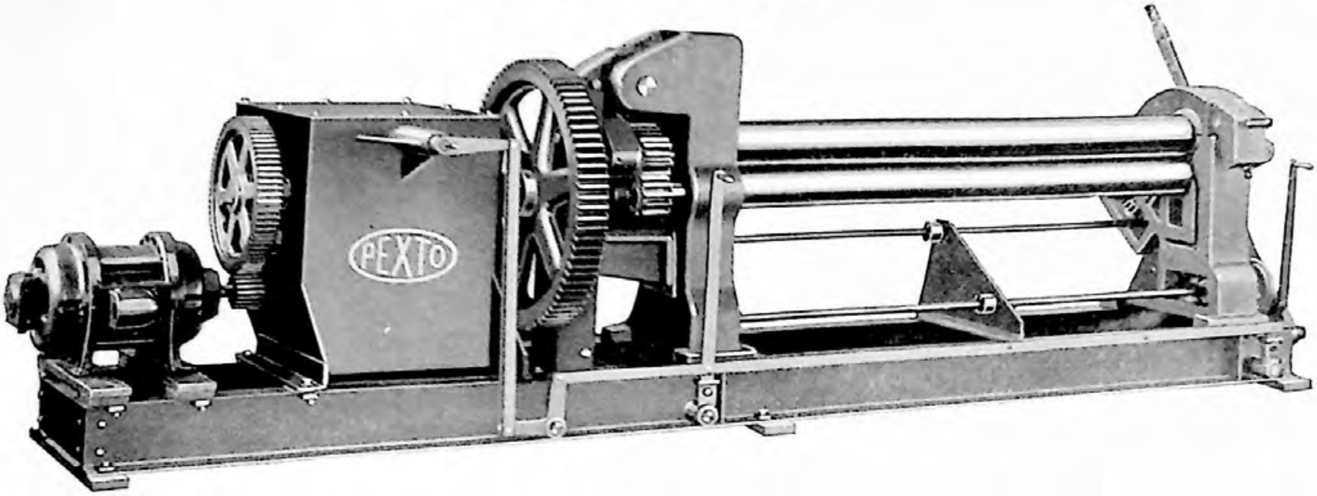
IMPROVED LIGHTNING POWER SLIP ROLL FORMING MACHINES

6 and 6½ INCH ROLLS

DOUBLE BACK GEARED

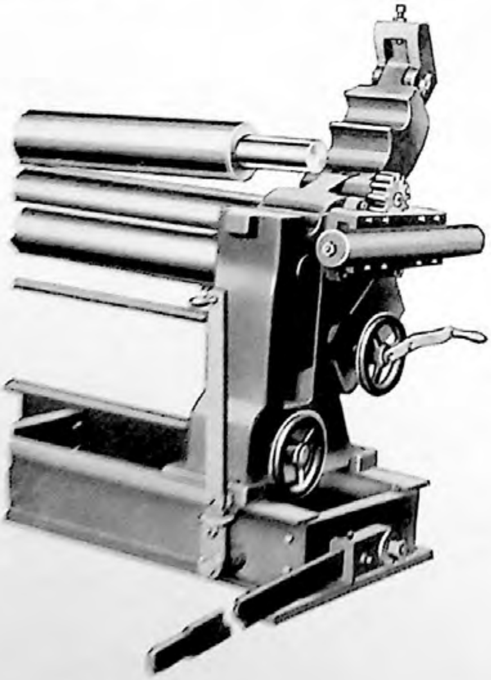
With Double Friction Clutch

For specifications see page 63



6 inch rolls as arranged with double friction clutch and geared motor drive attachment. Gear guards are furnished

This application of double friction clutch places the machine under full control of the operator. The clutch is controlled through levers located at each end of machine that locks automatically in three positions — forward, neutral and reverse. Furnished belt drive to be belted from line shaft or individual geared motor drive as illustrated.



Counter-balanced hinge cap construction

IMPROVED LIGHTNING POWER SLIP ROLL FORMING MACHINES

6 and $6\frac{1}{2}$ INCH ROLLS

DOUBLE BACK GEARED

With Double Friction Clutch

See illustration page 62

Number—Pulley drive with double friction clutch	**446**	**447**	**448**	**449**	**478**	**479**
Number—Geared motor drive with double friction clutch	**1446**	**1447**	**1448**	**1449**	**1478**	**1479**
Length of rolls for sheets ... ins.	72	96	120	72	96	120
*Capacity for soft steel ... ga.	7	10	14	5	8	10
Diameter of rolls ... ins.	6	6	6	6½	6½	6½
Ratio of gearing ...	20:1	20:1	20:1	20:1	20:1	20:1
Speed of rolls ... r.p.m.	15	15	15	15	15	15
Speed of drive pulley ... r.p.m.	300	300	300	300	300	300
Size of drive pulley ... ins.	26x5	26x5	26x5	26x5	26x5	26x5
Motor required ... h.p.	7½	7½	7½	7½	7½	10
Speed of motor ... r.p.m.	1200	1200	1200	1200	1200	1200
Floor area ... ins.	84x176	84x200	84x224	84x176	84x200	84x224
Shipped on skids, pulley drive ... approx. lbs.	8400	8800	9200	8700	9200	9700
Shipped on skids, motor drive, less motor, approx. lbs.	8700	9100	9500	9000	9500	10000

NOTE:—Geared motor drive arrangement does not include motor or motor guard. Motor pinion is included.

Our heaviest Forming Machines are represented in these patterns. The machine rests directly on a bed constructed of steel I-beams not requiring any intermediate legs.

The application of double friction clutch places the machine under full control of the operator. **This clutch is of the Carlisle Johnson type** selected after extensive tests proving most reliable and suitable for this type of Forming Machine. It is controlled through levers located at each end of machine always within easy reach of the operator and **locks automatically in three positions — forward, neutral and reverse.**

The lift type of Slip Roll Former is preferable in order to gain advantage of the best principles in Forming Machine construction and operation.

All three rolls are driven through compensating gears having bearings of cast iron but the upper roll bearing in the right hand housing is babbitted. Ample clearance is provided at left end housing for removing work when formed the full length of rolls. Furnished with three longitudinal grooves in rear forming roll.

Lifting of the upper roll is effected through a lever on right end of machine and locks automatically with the roll in tilted position.

The high speed gears and clutch mechanism are totally enclosed in the gear box running in oil requiring no attention. Bearings in the gear box are bronze bushed employing alemite system for lubrication. Grease gun is furnished. A solidified oil such as alemite is recommended for best results.

Any weak over-hung parts are eliminated through the use of a hinged cap fitted to the right end housing provided with counterbalance for ease of operation.

The rolls need not be stopped when operating the lifting device. A desirable feature as can be obtained only in this design of open end Formers.

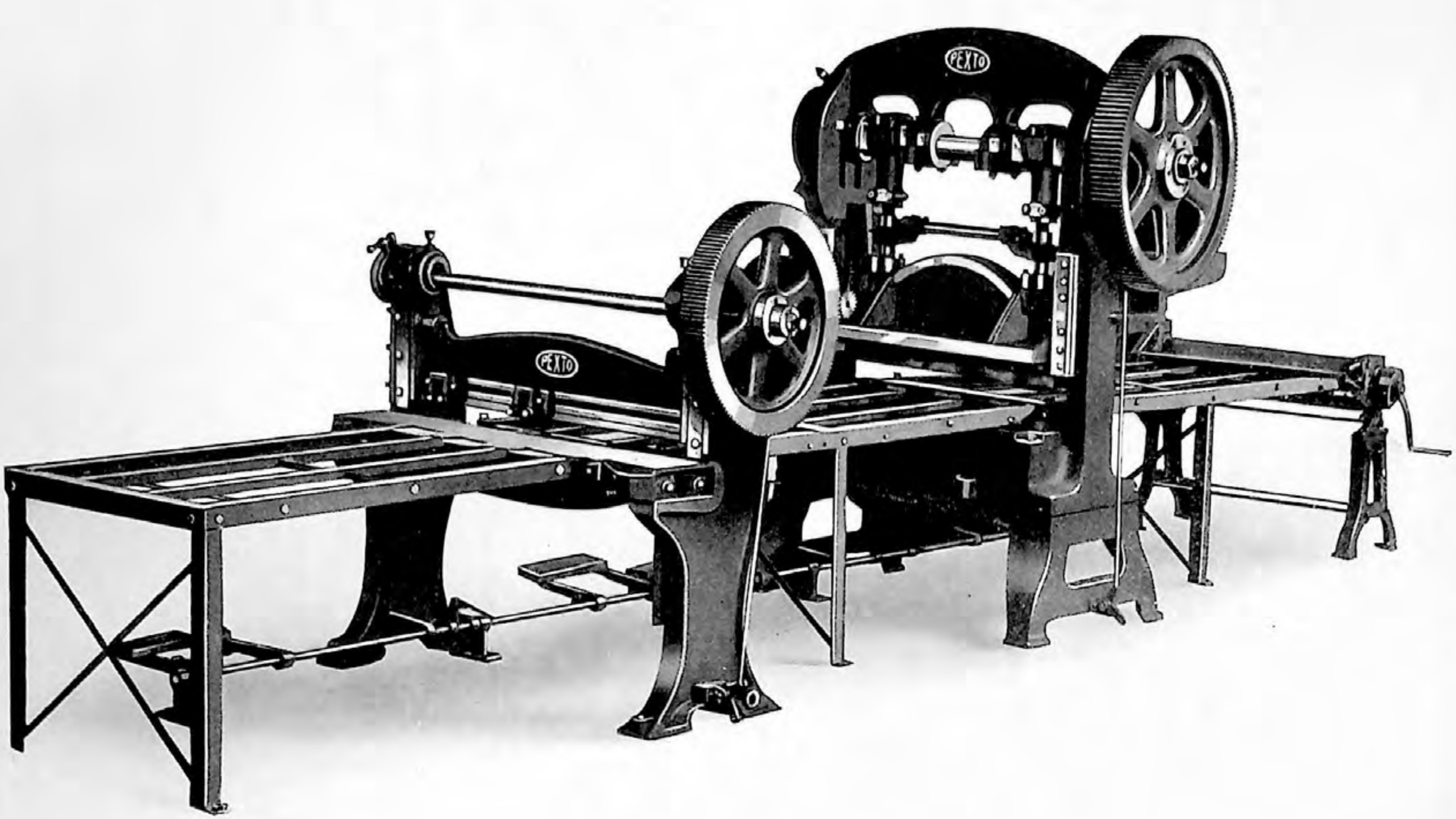
The adjustment of the lower and rear forming roll is effected by means of a hand wheel mounted on a horizontal shaft which operates the adjusting screw through worm and worm wheel, assuring parallel motion of the lower roll in relation to the upper roll.

A coupling is provided on the hand wheel shaft for the dis-engagement of the adjusting device if desired to place the rear forming roll on a slight angle for tapered work, but this adjustment allows for a very slight taper in order to avoid binding of the roll.

Power device for raising and lowering of rear forming roll can be applied at extra cost. This power device will be operated by an individual electric reversible motor.

Rolls are high carbon steel smoothly ground.

* Reference—"Capacities" Page 50.



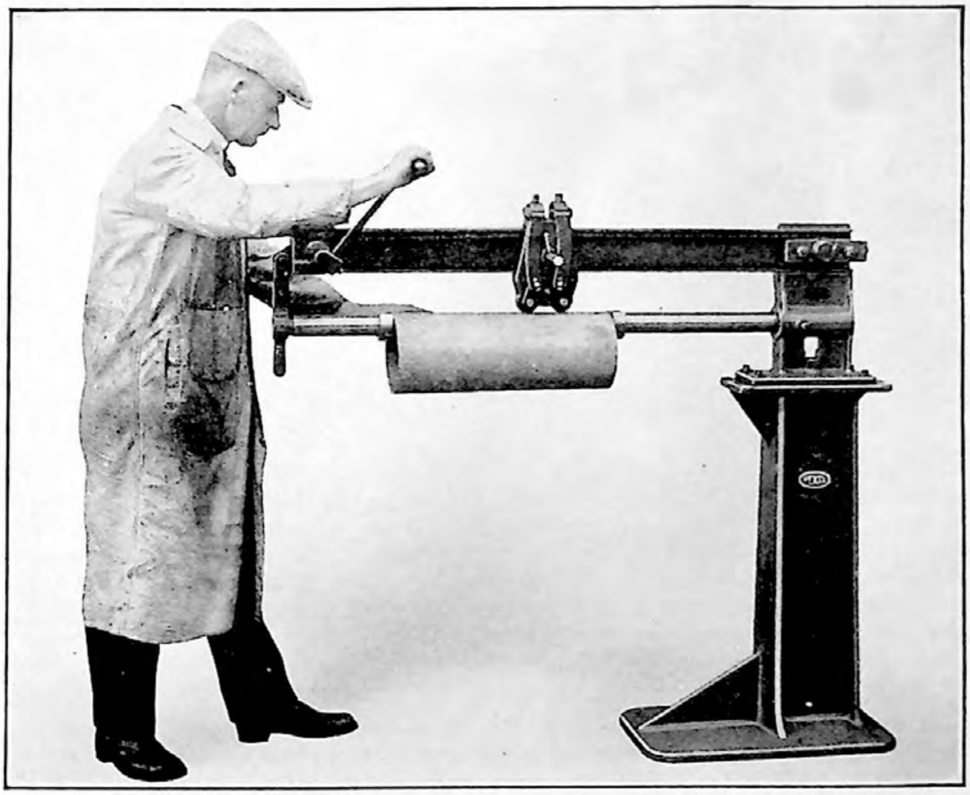
NOTCHER, SIDE SEAM PRESS AND FORMING ROLLS WITH CONNECTING TABLES

For the manufacture of light drums on large production basis, we manufacture a complete line of Power Shears, Presses, Side Seam Closers, Corrugating Machines, Flanging Machines and Double Seaming Machines. (For complete information write for Bulletin No. 100)

PEXTO

Bulletin J-35

GROOVING MACHINES

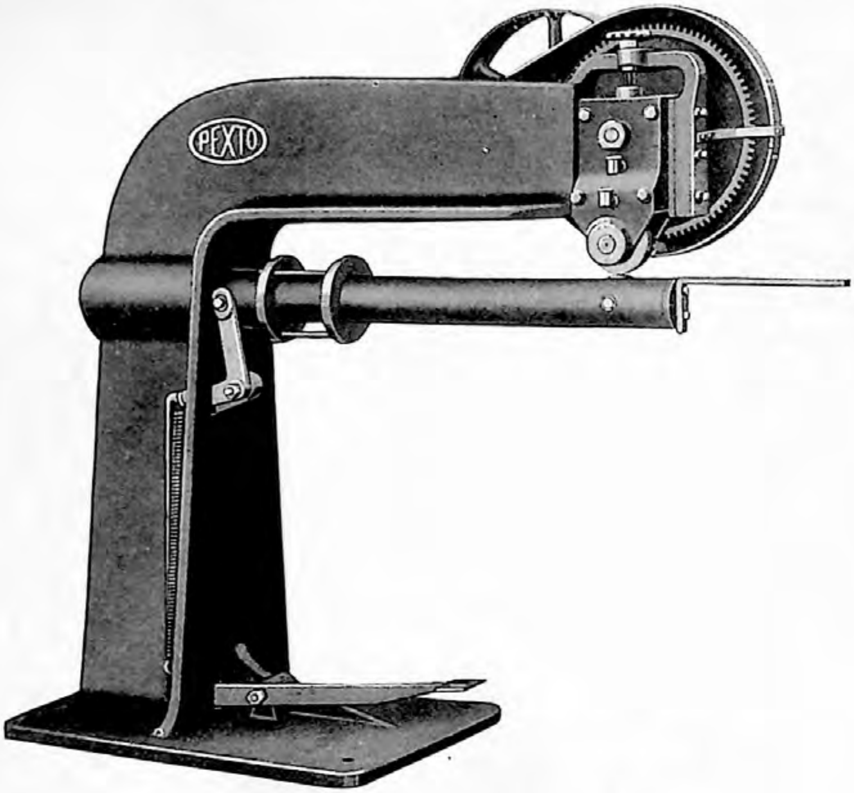


The definite superiority of PEXTO equipment has been proven by the practical consistent user in every part of the globe.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

POWER THROW OUT GROOVING MACHINE



Capacity — No. 24 gauge mild steel and lighter

Number		**491**
Will groove work, length	ins.	30
Diameter of grooving horn	ins.	$3\frac{15}{16}$
Size of pulley	ins.	18x4
Speed of pulley	r.p.m.	225
Grooving speed	feet per minute	50
Horse power required	h.p.	1½
Speed of motor	r.p.m.	1200
Shipped regularly on skids	approx. lbs.	1670

Note:—Shipped regularly with pulley. Can be arranged with geared direct connected motor. State width of seam required and gauge of materials to be used.

The production manufacturer of smoke and heater pipe will find interest in these patterns because they differ so widely from the ordinary Grooving Machines. There is no moving carriage.

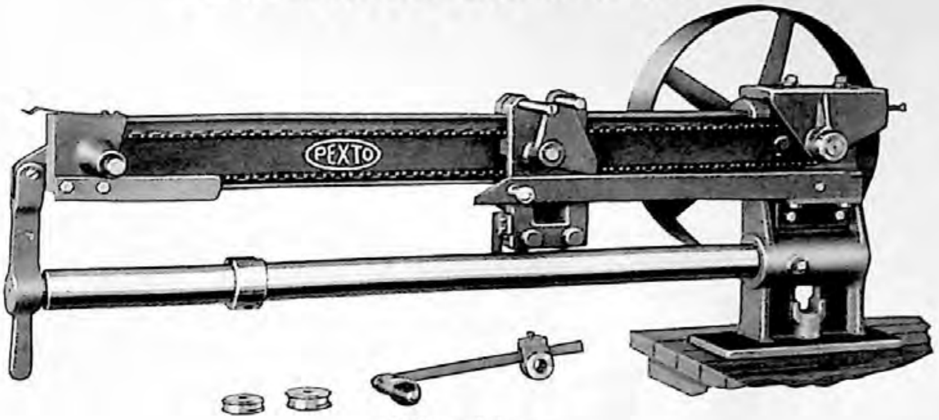
In the regular way the work is hooked together over the horn. A slight pressure on the treadle which is connected with a forcer starts the work between the rolls, grooving the seam and discharging the finished work on to an extension fitted to grooving horn.

The machine is built for outside seam grooving but if required grooves can be cut in the horn for locating seams on the inside of work.

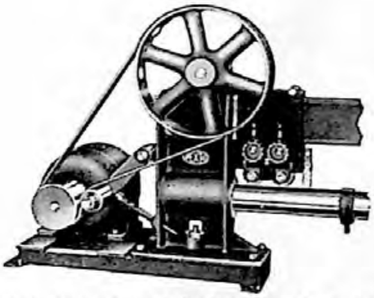
They cost more than the Standard Grooving Machine but will soon pay for themselves. Especially for stove pipe that must be made so cheaply, a machine of this kind will groove the seams with rapidity.

Let us know about your own grooving problem — We can help you.

POWER GROOVING MACHINE



Pulley drive



Direct connected belted motor drive

Capacity — No. 24 gauge mild steel and lighter

Number—Pulley drive		523
Number—Belted motor drive		2523
Will groove work, length	ins.	30
Diameter of smallest pipe that can be grooved	ins.	2
Size of tight pulley	ins.	16x3
Speed of pulley	r.p.m.	180
Horse power required when arranged belted motor drive	h.p.	¾
Speed of motor	r.p.m.	1200
Size of motor pulley	ins.	2½
Shipped boxed	approx. lbs.	250

NOTE:—Furnished with grooving rolls one each ¼, $\frac{5}{16}$ and ⅜ inch and two flattening rolls. Regularly furnished for bench use but floor pedestal can be supplied at extra cost.

With the use of this type of grooving machine the seam is grooved and flattened simultaneously on the forward run of carriage. After the grooving carriage has finished its run forward and the grooving of the seam in the work is completed, the carriage is disconnected and returned by hand thru pushing against a lever provided on the carriage. The work grooved is then removed by disconnecting the latch and the machine is again ready for the next piece to be grooved. Starting of the carriage is effected by means of a slight pull on a release lever. Adjustable stop is provided on the upper bar for stopping the carriage at any point. The carriage bar and grooving horn are steel.

Grooves are cut in grooving horn and also have one flat surface for locating seams on the inside or outside of work.

So simple in construction that they can be used to advantage by the small shop owner and will prove more practical and speedier than anything of its kind large shops were compelled to use before the introduction of these patterns. When arranged pulley drive hand crank is furnished for operation by hand or power.

HEAVY RAPID GROOVING MACHINES

For illustration see page 69

Number—Hand drive	**520**	**516**	**517**
Number—Pulley drive	**0520**	**0516**	**0517**
Number—Flat belt or v-belt motor drive	**1520**	**1516**	**1517**
Capacity, soft steel and lighter......gauge No.	20	20	22
Will groove work, length......ins.	36	42	48
*Diameter of grooving horn......ins.	3	3	3
Smallest pipe which can be grooved, diameter......ins.	3½	3½	3½
Size of tight pulley......ins.	14x3	14x3	14x3
Speed of pulley......r.p.m.	500	500	500
Linear speed of grooving carriage when arranged power drive......feet per minute	100	100	100
Horse power required......h.p.	1½	1½	1½
Speed of motor......r.p.m.	1800	1800	1800
Motor pulley dimensions, face......ins.	3½	3½	3½
Shipped boxed, hand drive......approx. lbs.	410	435	460
Shipped boxed, pulley drive......approx. lbs.	460	485	510
Shipped boxed, belted motor drive......approx. lbs.	500	525	550

NOTE:—Furnished with two flattening rolls and 9/16, 7/16 and 5/16 inch grooving rolls. Regularly furnished for bench use but floor pedestal can be supplied at extra cost.

* Can furnish with 2⅞ inch horn when so specified on order but capacity ratings will be reduced to No. 22 gauge on 42 inch and No. 24 gauge on 48 inch machines.

A heavy-duty Groover for hand, belt drive or belted motor drive as preferred. Intended for grooving the longitudinal seams in cylinders for locating the seam on the inside or outside of the work.

The hand machine is arranged as illustrated. The carriage driven by a sprocket chain can be operated either direct or geared and when in neutral, it can readily be shifted by hand.

For power drive the carriage is driven with sprocket chain and will stop automatically when the carriage has completed its run forward or backward. The motion of carriage is reversed by tripping a small hand lever.

For hand or power the grooving carriage has two rolls, the grooving taking place on the forward run flattening the seam on the return run of carriage. Adjustments are provided for exerting the proper pressure of rolls.

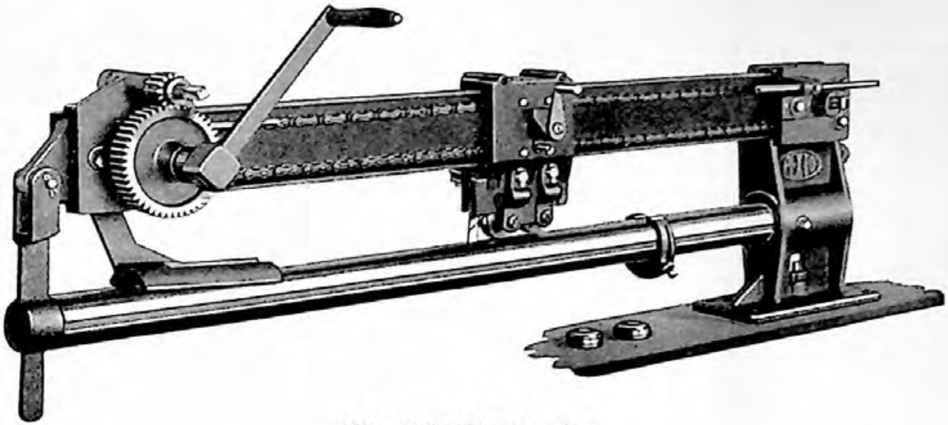
The grooving horn can be revolved having a flat surface and milled grooves for locating seams on the inside or the outside of the work. When an inside seam is desired, two flattening rolls are used on the carriage and the grooving horn is set to the correct width of groove. When an outside seam is desired, the horn is set with flat surface up and the carriage then utilizes one flattening roll and one grooving roll of correct width.

The frame is cast iron. Bar supporting grooving carriage and the grooving horn are steel.

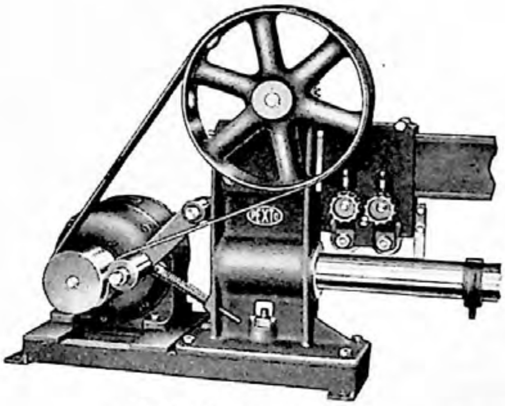
A guide is fitted to the carriage and horn is provided with stops to fix position of work.

HEAVY RAPID GROOVING MACHINES

For specifications see page 68

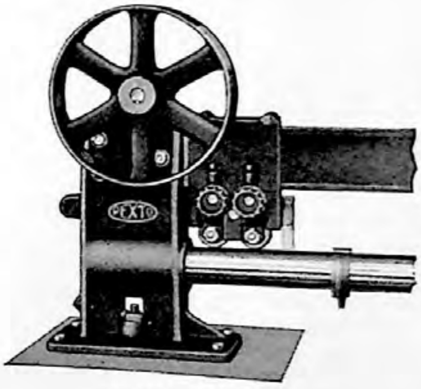


No. 520 Hand drive



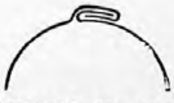
Belted motor drive

Gear guard furnished

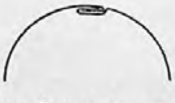


Pulley drive

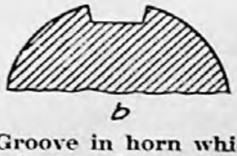
Belted motor drive, includes motor bracket, self-adjusting idler or belt tightener, but does **not** include belt, guard, motor pulley, motor or other electrical equipment. We will supply the motor if desired, in which case complete available electric current specifications should be stated.



Seam located on outside of work using the flat section of horn with grooving and flattening rolls fitted to the grooving carriage

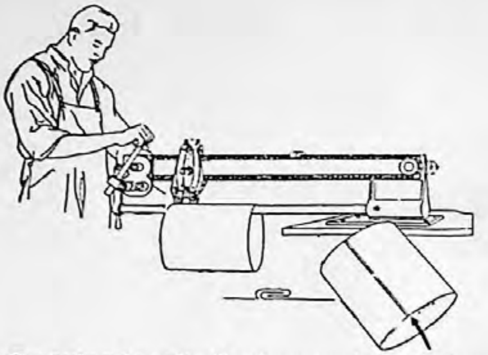


A—Seam located on inside of work

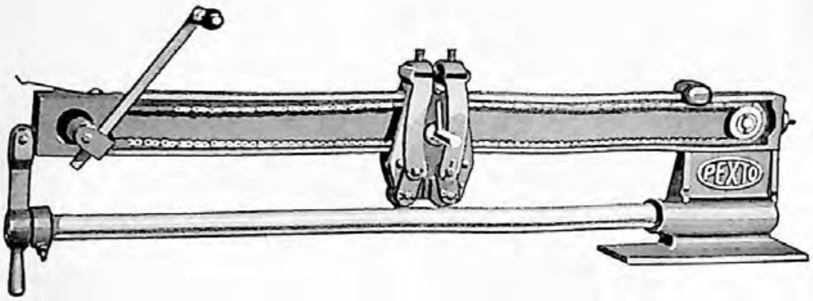


B—Groove in horn which is turned upward and when flat roll is used for locating seams on inside of work

RAPID GROOVING MACHINE



Grooving longitudinal seams in cylinders locating the seam on the inside or outside of the work



Capacity — No. 24 gauge mild steel and lighter

Number		518
Will groove work, length	ins.	30
Diameter of smallest pipe that can be grooved	ins.	2
Shipped boxed	approx. lbs.	200

Furnished with two flattening rolls and ¼, 5/16, ⅜ inch grooving rolls. Furnished regularly for bench use. Floor pedestal as illustrated on page 65 can be supplied at an extra charge.

Widely in use for grooving the longitudinal seams in cylinders for locating the seam on the inside or outside of the work. It differs from the ordinary Groover in that the operator does not have to change his position when inserting and removing work and operating the machine.

Grooving carriage is so arranged that the flattening roll runs idle on the outward run, the grooving roll running idle on the backward run. The two rolls do not press the seam simultaneously making for easier grooving.

Frame is cast iron. The bar supporting the grooving carriage is steel and the grooving horn is steel. The carriage is driven by a sprocket chain and when in neutral it can readily be shifted by hand.

Grooving horn is reversible so that either the flat surface or one one of the grooves milled in the horn can be turned upward permitting for the locating of seams on the inside or outside of the work.

When an inside seam is desired two flattening rolls are used on the carriage and the grooving horn is set to the correct width of groove. When an outside seam is desired the horn is set with flat surface up and the carriage then utilizes one flattening roll and one grooved roll of correct width.

Stops are provided to fix position of the work.

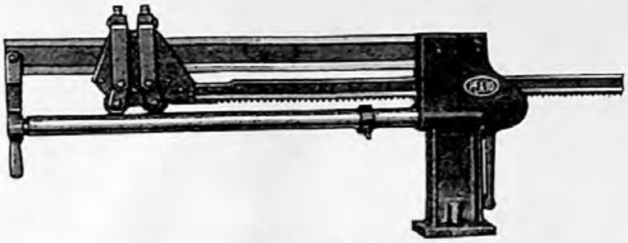
GROOVING MACHINES

GENERAL PURPOSE GROOVER

Capacity — No. 22 gauge mild steel and lighter

Number	507
Will groove work, length ......ins.	30
Diameter of smallest pipe that can be grooved ......ins.	2
Shipped boxed ......approx. lbs.	185

Furnished with two flattening rolls and ¼, 5/16 and ⅜ inch grooving rolls. Furnished regularly for bench use. Floor pedestal extra.



No. 507

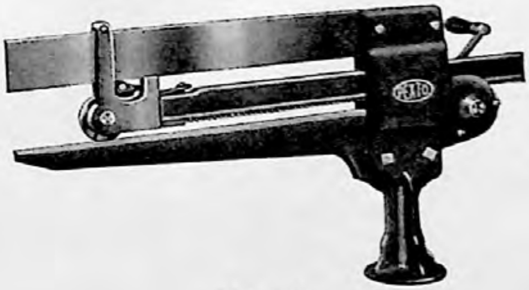
In these machines the grooving carriage is driven thru rack and pinion. Since the introduction of the chain drive Groover, the demand for this type of Groover is limited, retaining the same in the line for the old-time sheet metal craftsman who has a special preference for this type of Groover. The grooving carriage is driven by a hand crank from rear of machine. The grooving horn has a flat surface and three grooves milled in the same for locating seams on the inside or outside of work. The grooving takes place in the forward run, flattening the seam on the return run of carriage.

SHORT HORN GROOVER

Capacity — No. 24 gauge mild steel and lighter

Number	502
Will groove work, length ......ins.	20
Size of grooving horn, large end ......ins.	3
Size of grooving horn, small end ......ins.	1⅝
Shipped boxed ......approx. lbs.	110

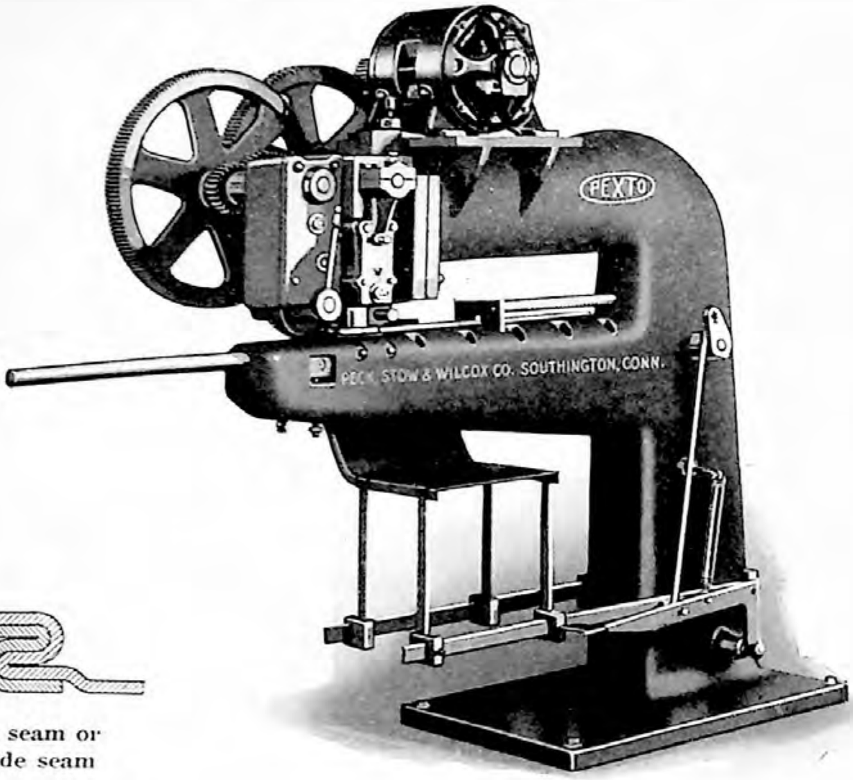
Furnished with three grooving rolls 3/16, ¼, 5/16 inch.

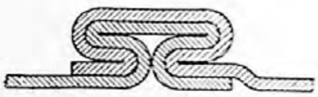


No. 502

A simple machine for short work and where seams are invariably located on the outside of the work. Used with great success in countless shops for over one hundred years and is still the favorite with many users.

POWER SIDE SEAM CLOSERS





Pexto box seam or Gordon side seam

Number	1110-30	1110-42
Size ins.	30	42
Capacity gauge	22	22
For seaming drums, length ins.	30	40
Linear speed feet per minute	40	40
Minimum diameter of work that can be seamed ins.	13	15
Size of pulleys ins.	18x4	18x4
Speed of pulleys r.p.m.	175	175
Horse power required h.p.	2	2
Speed of motor r.p.m.	1200	1200
Shipped on skids approx. lbs.	2300	2900

Furnished pulley drive, geared, or v-belt motor drive as may be specified.

The PEXTO box seam shown in the illustration offers a mechanically-made seam absolutely secure. With the use of this seam rivets or punch marks do not have to be resorted to for preventing seam from springing open. This design of machine can be used only for the box seams described, the side seam being previously prepared on a Side Seam Press with suitable dies which we can also furnish. The seam to be closed is hooked over the horn in the usual way. There is no movable carriage. The machine closes the seam, discharging the finished work from the horn.

Employed extensively in the production manufacture of steel drums or containers. The PEXTO complete line of Power Steel Drum Equipment is offered in Bulletin No. 100.

PEXTO

Bulletin K-35

ROTARY MACHINES

HAND & POWER DRIVES

Maximum rigidity and accurate alignment improve the quality and facilitate the production. Pexto machines are designed and built to give that performance.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

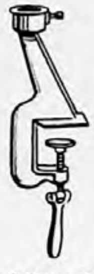
"Our Second Century"

REVOLVING MACHINE STANDARD

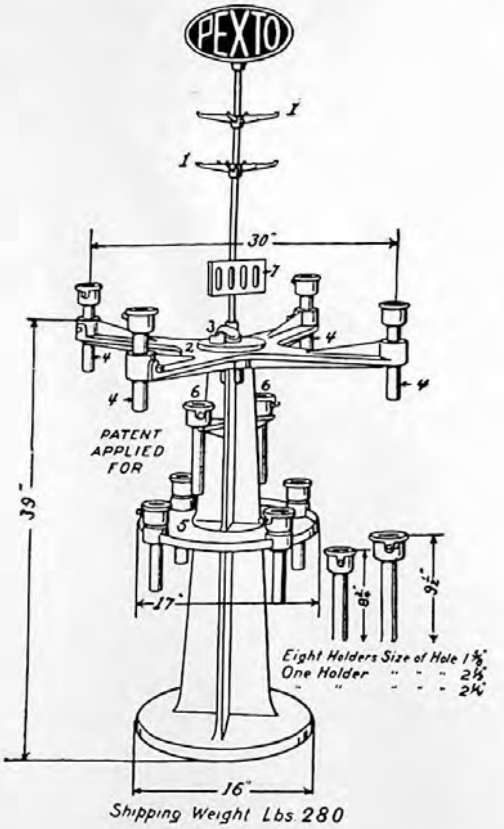
HOLDS EIGHT SMALL MACHINES

Four active and four inactive

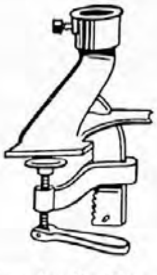
A practical shop Standard that saves bench room



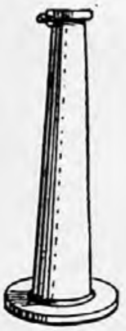
Regular Offset No. 975



Shipping Weight Lbs 280



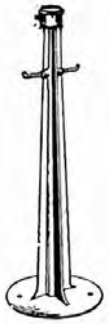
Heavy Standards Nos. 977-978



Heavy Floor Standard No. 979

No. 969

Holdall Revolving Machine Standard



Light Floor Standard No. 984

Holders are adjustable to any position. Upper turret revolves. Clamp provided to hold turret rigid. A place for everything — Everything in its place. Regularly furnished with ten machine holders.

NOTE:—Where this Standard is employed the Regular Bench Standards for machines are not required—Save money—Use this Standard and order all small machines less Regular Bench Standards.

BENCH AND FLOOR STANDARDS

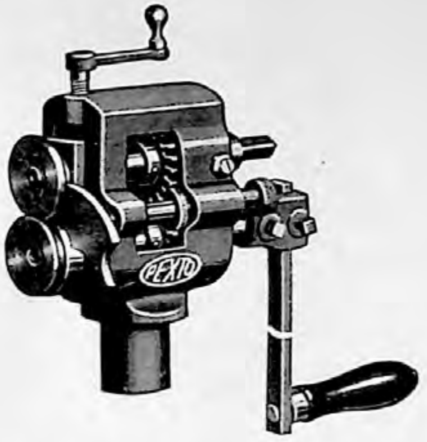
Number	975	977	978	979	984
Size hole ....ins.	1⅝	2¼	2½	2¼ and 2½	1⅝
Height over all from bench ....ins.	9¾	10⅛	9⅞		
Height over all from floor ....ins.				39	39
Shipping weight ....lbs.	11	23	24	90	50

NOTE:—*In making Machine Standard substitutions, deduct full price of Standard as regularly furnished with the machine and add full price of Standard required. When machines are ordered not to have any Standard deduct half price of Standard omitted. When ordering Standards separate from machines mention diameter of machine stem, if same does not correspond to hole dimensions given.*

Bench Machines having stems larger than 1⅝ inches will fit in Heavy Floor Standard No. 979, but the hole required for fitting the machine in use must be specified. If correct number of the machine for which Floor Standards are required is given, size of hole for Floor Standard is not necessary. The Light Floor Standard No. 984 has a 1⅝-inch hole and will receive small machines having stems of corresponding dimensions.

UNIVERSAL COMBINATION ROTARY MACHINE

This one machine with any of its interchangeable rolls will take care of the common TURNING, WIRING, BURRING and ELBOW EDGING OPERATIONS.



The rolls as illustrated are interchangeable. The crank is interchangeable for fitting to upper or lower shafts to drive rolls forward or reverse. The gauge is also interchangeable for use in front or rear of machine. Rolls cannot slip or bind on their arbors, as they are held to key-seated arbors with screw nuts. The frame is solid and gears are machine cut from solid steel.

Capacity — No. 22 gauge soft steel and lighter.

Diameter of rolls — 2 inches.

Shipping weight complete with No. 975 Standard — 33 lbs.

No. 544 — Without any rolls complete with screw nuts for holding rolls and offset standard and spanner wrench.

No. 1544 — With (A) thin turning rolls, (B) thick turning rolls, (C) burring rolls including spare upper burring roll, (D) wiring rolls and offset standard and spanner wrench.

Elbow Edging Rolls No. 1 will be included only when specified and are furnished at an extra cost.

No. 2544 — With (A) thin turning rolls, (B) thick turning rolls only including offset standard and spanner wrench.

No. 3544 — With (C) burring rolls only including spare upper burring roll and offset standard and spanner wrench.

No. 4544 — With (D) wiring rolls only including offset standard and spanner wrench.

No. 5544 — With No. 1 elbow edging rolls only including offset standard and spanner wrench.

NOTE: At an extra cost any of the above machines can be furnished with foot treadle attachment instead of crank screw for depressing upper roll.

A

B

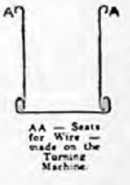
C

D

No. 1

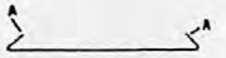
STANDARD ROLLS

Interchangeable with Pexto Universal Combination Rotary Machine

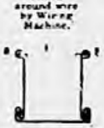


"A"—Thin turning rolls curl tops of vessels for receiving wire rings No. 11 gauge largest.

"B"—Thick turning rolls for largest wire No. 7 gauge.

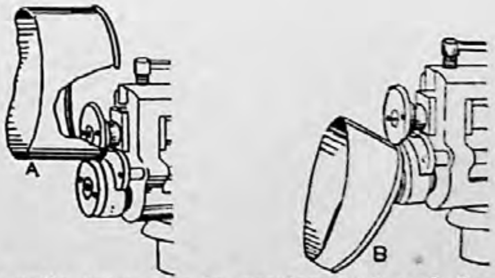


"C" — Burring rolls widest flange ¼ inch. A-A shows flanged disc.



"D"—Wiring rolls close metal snugly around wire. The seat for wire prepared with rolls A or B.

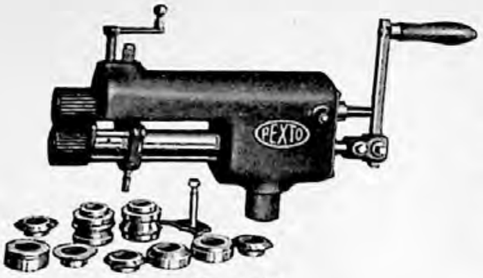
Largest wire No. 7 gauge.



No. 1 rolls turn a v in section "A" and flange in section "B" for elbow seams.

DEEP THROAT ALL-IN-ONE MACHINE

Five operations with one machine



No. 622

A utility rigid machine for small shops and maintenance departments of industrial shops. A rigid solid frame is employed with arbors and gears fully enclosed. Lower arbor bearings are bronze bushed. Gears are machine cut from solid steel. Adjustable steel crank can be attached to lower or upper arbors for driving rolls forward or reverse. Arbors are key seated to prevent roll slippage and rolls are countersunk, held to their arbors with round nuts. Five pairs of rolls and three gauging arrangements are provided to suit all five pairs of rolls included.

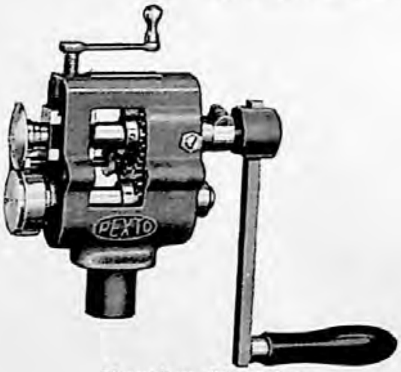
Capacity—Using crimping or beading rolls No. 26 gauge iron and lighter
Capacity—Using turning, wiring or burring rolls No. 24 gauge iron and lighter

Number		622
Depth throat to frame	ins.	7
Depth throat to gauge	ins.	6
Largest wire than can be used with turning rolls	ga.	11
Wiring rolls will receive wire up to	ga.	7
Widest flange or burr that can be turned with burring rolls	ins.	¼
Size of ogee bead in beading rolls	ins.	¾
Distance between shaft centers	ins.	2
Packed one in a box	weight approx. lbs.	60

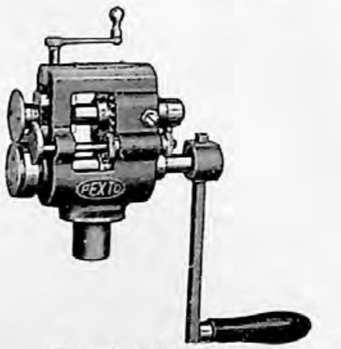
NOTE:—Furnished complete with Standard No. 975 and five pairs of rolls, viz.: crimping, beading, turning, wiring, and burring and suitable gauges. Turning, burring, wiring and elbow edging rolls are interchangeable with rolls for Combination Rotary Machines on page 75.

BENCH ROTARY MACHINES

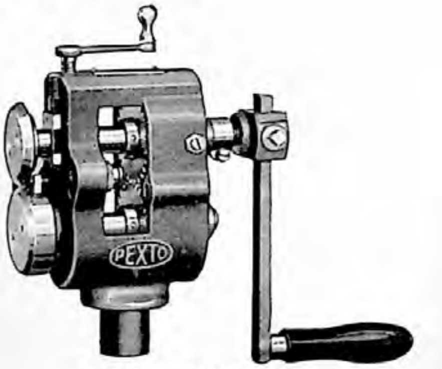
With rolls of smaller and larger diameters than Combination Machine page 75



Burring Machine
or
(Thin Edge)



Turning Machine
or
(Thick Edge)



Wiring Machine

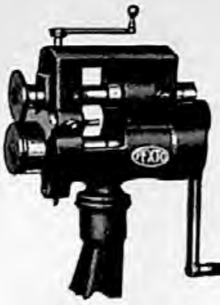
Number	Small Burring 576	Extra Small Turning 540	Large Turning 542	Wiring Machine 525
Diameter rolls, ins.	1½	1½	3	3
Widest flange or burr that can be turned, ins.	3/16			
Smallest wire that can be used, gauge No.		11	9	
Largest wire that can be used, gauge no.		13	4	0
Shipping weight, approx. lbs.	26	26	36	36
Packed one in a carton				

NOTE:—In these machines the rolls are threaded and are screwed on to threaded arbors. Gears are steel, machine cut. Cranks are steel and adjustable. Furnished complete with Standard No. 975. Extra upper roll furnished with Burring Machines. One pair each thin and thick turning rolls with Turning Machines. Forming roll gauge can be furnished with Wiring Machines at an extra cost and only when specified. Foot treadle attachment for depressing upper roll in place of crank screw when specified can be furnished at an extra cost.

HEAVY ROTARY MACHINE

Turning capacity — No. 18 gauge soft steel with ¼ or 5/16 inch wire
Turning capacity — No. 20 gauge with 3/16 inch wire
With burring or wiring rolls — No. 18 gauge

Number	With Turning Rolls **0547**	With Wiring Rolls **0548**	With Burring Rolls **0584**	Combination Machine **C0547**
Diameter rolls ......ins.	3¼	3¼	3¼	3¼
Ratio of gearing	2:1	2:1	2:1	2:1
Smallest diameter wire that can be used..ins.	3/16	3/16	......	3/16
Largest diameter wire that can be used......ins.	5/16	5/16	......	5/16
Shipped boxed regularly ......approx. lbs.	130	130	130	140



No. 0547

NOTE:—One pair rolls furnished regularly with Nos. 0547, 0548 and No. 0584 machines. Turning Machines are furnished with turning rolls for 3/16 inch wire. On request we will substitute for ¼ or 5/16 inch wire. Rolls are interchangeable. One gauge will work with turning and burring rolls. Extra gauge needed for wiring rolls. No. C0547 Combination Machine regularly furnished with 1 pair each standard wiring and burring rolls and 1 pair turning rolls for 3/16 wire. Can substitute turning rolls for ¼ or 5/16 inch wire at no extra charge. Heavy Bench Standard No. 977 furnished regularly.

These machines are made from heavy patterns, and with the proper rolls and gauges, they are suited for a variety of operations. Machine cut steel connecting gears are used and the driving gears are cut from solid metal.

Extra Attachments

The above machine can be made up for power with tight or tight and loose pulleys or fitted with hand or treadle friction clutch mounted on iron floor pedestal. Apron gauge and elbow rolls can also be applied.

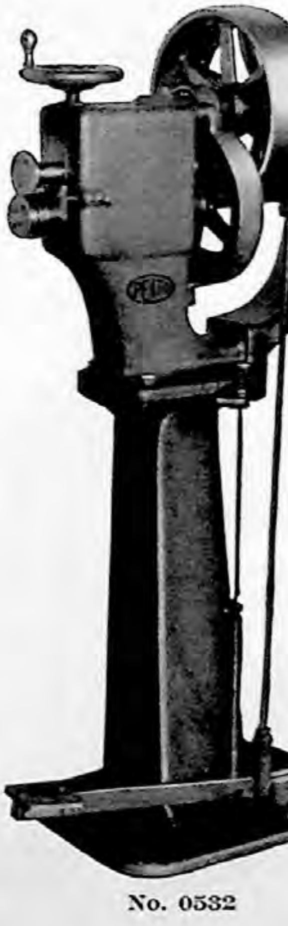
Flanging attachments can also be furnished and will be quoted on receipt of information pertaining to the smallest and largest diameter of discs to be flanged.

POWER ROTARY MACHINE

FOR HEAVY DUTY

Capacity — No. 16 gauge soft steel and lighter
Turning capacity — No. 16 gauge with ¼ or 5/16 inch wire
Turning capacity — No. 18 gauge with 3/16 inch wire
With wiring rolls — No. 16 gauge ⅛ to 5/16 inch wire
With burring rolls — No. 16 gauge

Number	Hand **532**	Belted Motor Drive **1532**	Pulley Clutch **0532**	T. & L. Pulleys **X532**
Diameter of rolls ......ins.	2⅜	2⅜	2⅜	2⅜
Ratio of gearing	4½:1	4½:1	4½:1	4½:1
Size of pulley ......ins.	......	......	12x3	12x3
Speed of pulleys ......r.p.m.	......	......	225	225
Smallest diameter wire that can be used ins.	3/16	3/16	3/16	3/16
Largest diameter wire that can be used......ins.	5/16	5/16	5/16	5/16
Horse power required ......h.p.	......	½	......	......
Speed of motor ......r.p.m.	......	900	......	......
Shipped crated regularly, weight, approx. lbs.	185	475	420	400



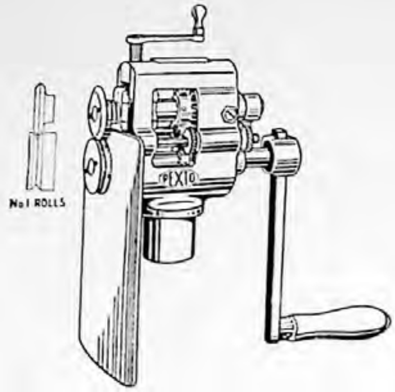
No. 0532

NOTE:—This machine is furnished regularly with turning and wiring rolls. Burring rolls are extra and will not be sent unless specified. Suitable gauge for turning rolls and an extra gauge for wiring rolls are included. The gauge as used with turning rolls will work in connection with burring rolls. Turning rolls included are for ¼ inch wire but on request will substitute for 3/16 or 5/16 inch wire as may be specified.

A self-contained machine that will perform a variety of operations with the necessary additional rolls.

Hand machine is furnished for bench use but can be furnished with floor pedestal if required. Power machines are regularly furnished with floor pedestals. The frame is solid, the shafts are heavy and bearings are bronze bushed. A production machine for heavy duty and well built for long wear. Pinions are steel, large gear is semi-steel, machine cut.

ELBOW EDGING MACHINES



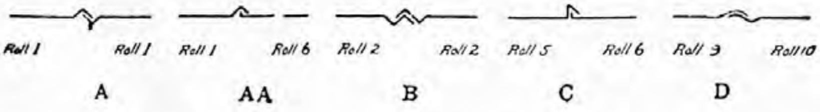
No. 5544

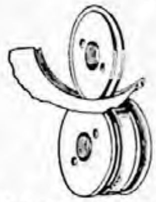
Capacity — No. 22 gauge soft steel and lighter

Number	550	5544
Old Number		551
Diameter rolls ....ins.	1½	2
Packed one in a box ....weight approx. lbs.	26	30

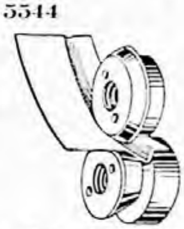
NOTE:—Apron gauge is not included unless ordered. Plain small gauge is standard. Furnished with Regular Offset Standard No. 975. No. 5544 will take on rolls page 75.

The standard No. 1 rolls furnished with these machines perform both operations as illustrated on page 75. The one elbow section is edged by revolving around lower roll and the other around the upper roll for tight or loose seam elbows with v seam.





Universal Elbow Edging Rolls

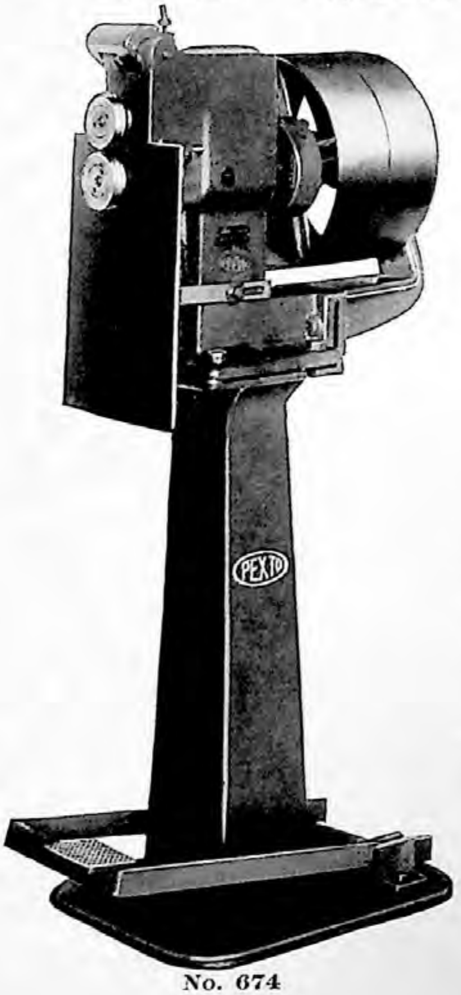


Universal Collar Edging Rolls

Extra Standard Elbow Rolls—that fulfill ordinary elbow edging requirements will fit No. 1544 Combination and No. 0547 Series Machines. Specify by their numbers.

Universal Elbow Edging Rolls—Standard for No. 551 and No. 1544 Combination Rotary Machine page 75. They have a wide groove for steel elbows and a narrow groove for tin elbows. They will operate without the use of false or curved gauge.

Universal Collar Edging Rolls—made for old No. 551 and new No. 544 Combination Rotary Machine page 75 will form deep bead or flange of full ¼ inch deep. The collars are cut to the right size and run thru the Collar Edging Rolls twice in the flat. The first operation makes about one-half the bead and the next operation the full bead. The collar is then formed up on the Forming Machine or rolls by using the deepest groove in the rolls of the Forming Machine.



No. 674

POWER ELBOW EDGER

Capacity — No. 24 gauge soft steel and lighter

Number	670	674
Size of rolls ....diameter, ins.	2	2⅞
Size pulleys ....ins.	12x3	12x3
Speed of pulleys ....r.p.m.	80	100
Ratio of gearing	....	2:1
Horse power required ....h.p.	½	½
Shipped boxed without pedestal ....approx. lbs.	150	260
Shipped crated with pedestal ....approx. lbs.	250	360

NOTE:—Can furnish for direct connected motor drive, specify roll speed desired and electrical current available. Where hand wheel in place of foot treadle is substituted for depressing the upper roll these machines will work on heavier iron. No. 670, No. 20 gauge; No. 674, 18 gauge. Can be furnished with or without iron floor pedestal.

A rigid machine for edging elbow sections. Frame is of one piece, shafts are extra heavy and bearings are bronze bushed. Pinions are steel and large driving gear semi-steel machine cut.

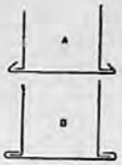
Rolls are quoted according to special shapes required. Straight or curved apron gauge as may be specified is included.

SETTING DOWN MACHINES

The Setting Down Machine makes ready the seams in body of vessels for double seaming.

(A)—Shows how bottom edge of body and bottom of can are prepared by Burring Machine.

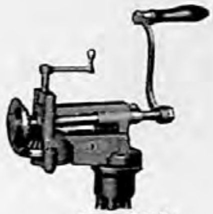
(B)—Shows seam as closed with Setting Down Machine preparatory to double seaming.



Capacity — No. 24 gauge iron and lighter

Number	556
For seams up to .... ins.	3/16
Packed one in a box .... weight approx. lbs.	23

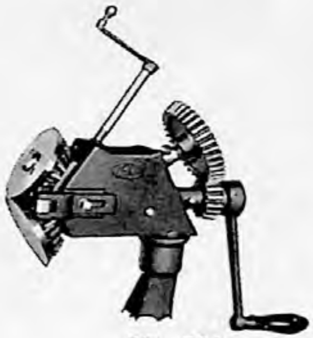
NOTE:—This type of Setting Down Machine is preferable for closing the seams in light tinware, etc. Regular Offset Standard No. 975 is furnished.



No. 556

Number	561	562
Capacity gauge iron and lighter .... No.	24	18
For seams up to .... ins.	⅜	½
Shipping weight .... approx. lbs.	60	100

NOTE:—Regular Offset Standard No. 975, is furnished with No. 561. Standard No. 977 with No. 562.



No. 561

GENERAL DESCRIPTION.

The improvements in this pattern Setting Down Machine adapt them for setting down the seams on differently shaped vessels to better advantage than any other design. The inclined position of both upper and lower faces allow work to be held up or down the seams to be started inward while setting down, thereby facilitating the operation of double seaming. Adjustable gauges with idler rollers are fitted.

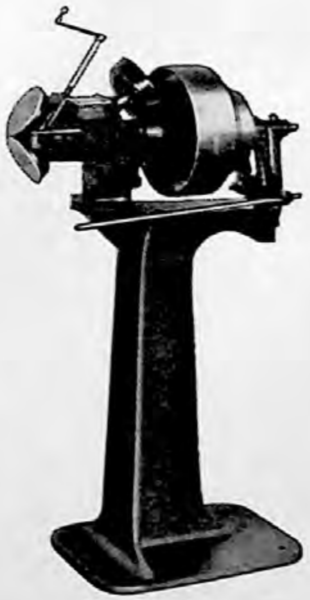
Capacity — No. 18 gauge iron and lighter

Number	0564
For seam up to .... ins.	½
Ratio of gearing	2:1
Size pulleys .... ins.	12x3
Speed pulleys .... r.p.m.	40
Shipped crated regularly .... weight approx. lbs.	310

GENERAL DESCRIPTION.

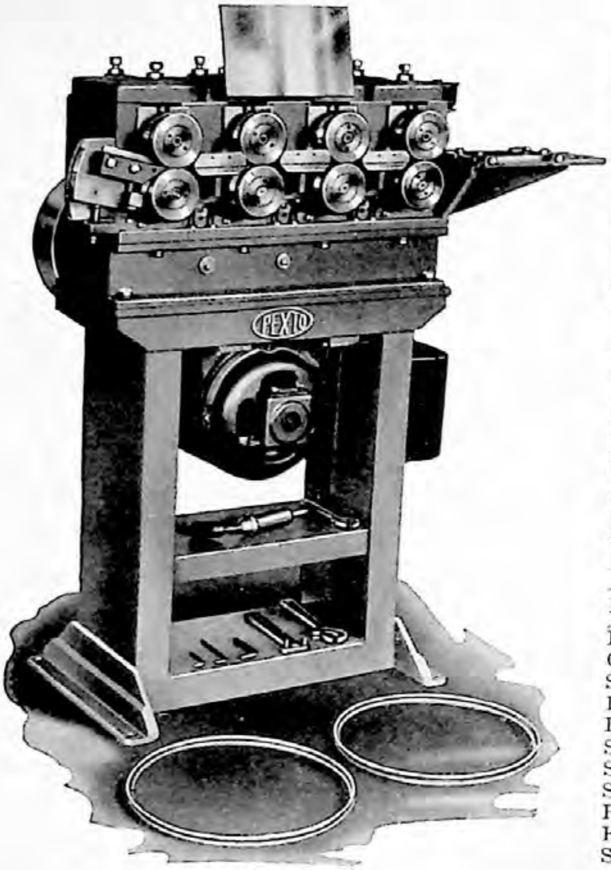
A durable Setting Down Machine with inclinable rolls commended for heavy duty and rapid execution. Fitted regularly with friction clutch attachment, controlled by an extension hand rod. Movement of clutch rod starts and stops the rolls instantaneously, thereby bringing the machine always under the operator's control. If preferred, treadle clutch can be substituted, but will not be fitted unless so ordered.

The inclined position of both upper and lower rolls allows for the work to be held up or down and for seams to be started inward while setting down, thereby facilitating the operation of double seaming to better advantage than with Setting Down Machine of other types. The adjustable gauges with idler rollers guide the seam while closing down with great accuracy.
A machine that may be used to good advantage in closing wide seams in a large variety of work.



No. 0564

POWER MULTIPLE ROLL FORMING MACHINES



No. 528

A machine having a wide range of production usefulness adapting itself to such work as weather stripping, barrel hoops, reinforcing rings and countless strip forming jobs. In addition to forming strip stock into various shapes with the application of forming shoes circular rings or spiral coils can be formed. It can also be adapted for hemming operations on one or both edges of narrow strips.

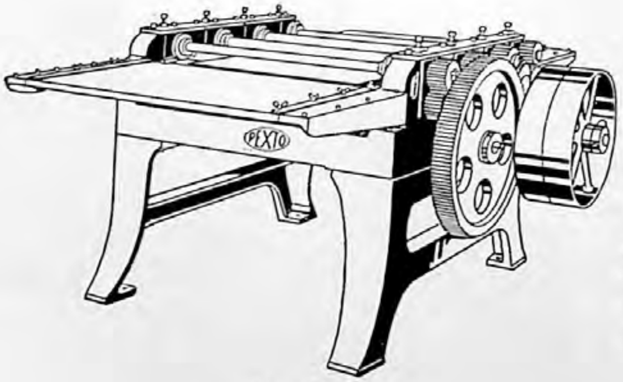
The machine is so designed that any number of roll units can be applied depending upon the section and shape to be formed.

All bearings are bronze bushed. All gears are steel and large drive gear semi-steel machine cut. Gears are completely enclosed.

Silent chain drive is standard when arranged for motor drive.

Furnished with a minimum of three sets of roll units but any number of roll units can be fitted depending on the kind of work to be performed.

Number		**528**
Diameter of rolls	ins.	3½
Center distance between roll units	ins.	6½
Speed of rolls	r.p.m.	107
Diameter roll shaft in bearings	ins.	1¾
Diameter roll shaft extension	ins.	1½
Speed in feet per minute		98
Speed of drive shaft	r.p.m.	250
Size of pulleys	ins.	14x3
Ratio of gearing		2.3 to 1
Horse power required (depending on work)	h.p.	2 to 3
Shipping weight—three unit machine	approx. lbs.	700



No. 78

POWER HEMMING MACHINE

Where a great many of the same size of sheets are to be locked seamed or edged the Hemming Machine will replace many Hand and Power Bar Folders. Forming locks on two edges of sheets in one pass with rapid precision it is faster than a press. The rolls and gauges adjust as a unit for various widths of sheets. Advise us of your production folding problem and we will give you the benefit of our counsel.

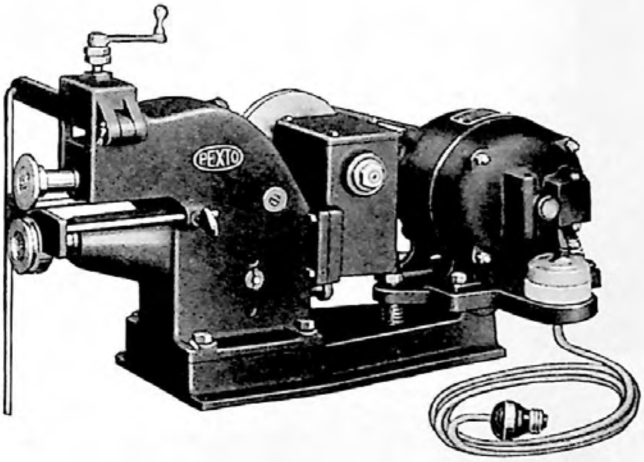
Number		**75**	**76**	**77**	**78**
For width of sheets	ins.	To Specifications			
Capacity soft steel	Gauge No.	33	28	22	18
Size of pulleys	ins.	6x2¼	8x3	20x3½	24x4½
Speed of pulleys	r.p.m.	280	280	220	220
Capacity feet per minute		150	150	100	100

NOTE:—When preferred we can arrange these machines with direct connected motor.

PEXTO

Bulletin L-35

ELECTRIC ROTARY MACHINES



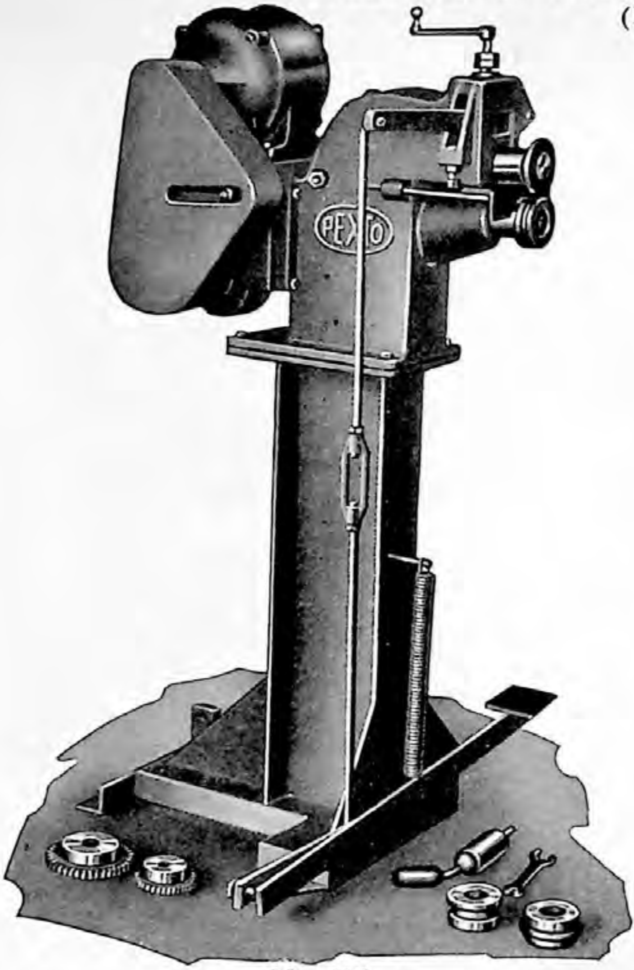
Pexto Electric Rotary Machines are designed to meet modern production needs economically. They contribute many valuable improvements to modern rotary machine operations.

THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

SPEED KING ELECTRIC ROTARY MACHINES

(Patented)



No. 626

THE ONLY MACHINE OF ITS KIND EMBODYING ALL THESE VALUABLE FEATURES

No. 626	No. 627
Maximum No. 18 gauge soft steel	Maximum No. 16 gauge soft steel

Foot treadle or crank screw for depressing upper roll.

Double friction clutch — hand operated or for foot control (both regular equipment). Forward or reverse drive. Locks in three positions automatically.

Three speeds through simple quick change of sprockets.

Silent chain drive from motor.

One chain and three sprockets regular equipment.

Positive lateral adjustment of upper roll for proper alignment and for tilting upper shaft for crimping rolls.

Alemite Zerk lubrication. Grease gun furnished with every machine.

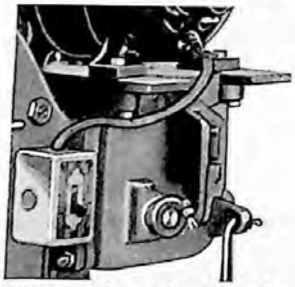
Completely enclosed gear box, gear and clutch mechanism running in light grease.

All bearings bronze bushed.

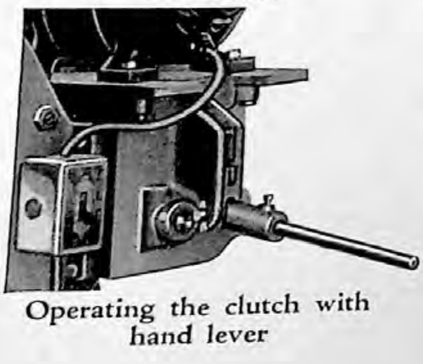
One-piece heavy frame of rigid design.

All-steel, strong pedestal.

Forged two-piece crank screw with lock nuts.



Operating the clutch with foot treadle



Operating the clutch with hand lever

Can be furnished with single or double clutch or without clutch. All three styles are individual motor drive and motors are included.

The advantage of the double friction clutch is found when a variety of operations are required from the one machine allowing for rolls to run forward or reverse and for starting and stopping rolls instantaneously.

Single clutch—when rolls can run in one direction and the work requires a clutch for instantaneous starting and stopping of rolls.

Without clutch—for varied production work where different operations require faster or slow speed of rolls and where the foot treadle attachment proves a sufficient means for releasing contact of the rolls quickly and thereby stopping progress of work through the rolls.

When arranged with clutch the operation of clutch is by hand or by foot treadle as best suited for the work. When using hand lever the treadle attachment or crank screw is used for depressing the upper roll.

SPEED KING ELECTRIC ROTARY MACHINE

Illustration Page 82

MAXIMUM CAPACITIES

	No. *626	*627
Crimping and Beading	20	18
Crimping only	18	16
Beading only	18	16
Turning, Burring and Wiring	18	16
Elbow Edging	18	16
Slitting	16	14

* Specify (DFC) with double friction clutch or (SFC) with single friction clutch or (NOC) without clutch. Affix letters always before the stock numbers.

STANDARD SPECIFICATIONS

		No. 626	627
Shipping Weight	lbs.	340	425
Shipping Weight, less Pedestal	"	275	350
Distance between Shaft Centers	ins.	2½	3
Length of Arbors for Rolls	"	2¾	2¾
Diameter of Arbors in Bearings	"	1¼	1½
Depth of Throat from Outer End of Arbors to Frame	"	7	6¾
Depth of Throat from Outer End of Arbors to Gauge	"	6¾	6
*Speed of Rolls	R. P. M.	25–41–51	22–35–44
*Speed of Rolls in feet per minute		17–27–34	17–27–34
Horse Power of Electric Motor	H. P.	½	¾

* Respective speeds given are procured by means of changing one sprocket. Three sprockets for the three speeds specified above, idler sprocket and chain furnished regularly.

Gauges and rolls are extra. See schedule pages 84 and 85.

ELECTRICAL EQUIPMENT

No. 626 — Furnished regularly with ½ h. p. 1800 r. p. m. motor for 60 cycle 1, 2 or 3 phase 110-220-440-550 volt current as may be required. Starter of type as may be specified can be furnished at extra charge.

No. 627 — Furnished regularly with ¾ h. p. 1800 r. p. m. motor for 60 cycle 1, 2 or 3 phase 110-220-440-550 volt current as may be required. Starter of type as may be specified can be furnished at extra charge.

Can furnish motors for other current with adjustment in price depending on difference in motor costs.

SPECIAL SPEEDS — Nos. 626 - 627

The construction of Pexto Electric Rotary Machines provide for higher speeds than regular depending upon what operation the rolls must perform and the thickness of metal used. There is an extra charge for all higher speed changes over regular. Any one of the three following speed ranges can be arranged instead of the above standard speeds.

300, 238, 146 r. p. m. with 1 h. p. motor for Nos. 626, 627

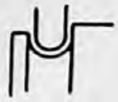
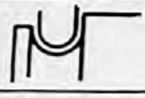
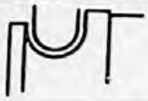
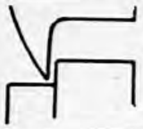
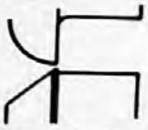
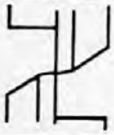
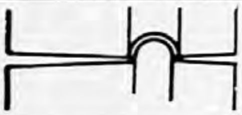
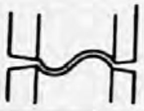
202, 164, 100 r. p. m. with ½ h. p. motor for No. 626; ¾ h. p. for No. 627

102, 82, 50 r. p. m. with ½ h. p. motor for No. 626; ¾ h. p. for No. 627

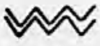
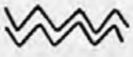
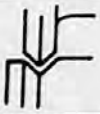
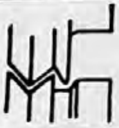
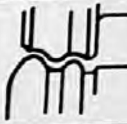
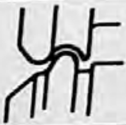
Example: Arranged for speed of 300 r. p. m. through means of changing sprockets lower speeds of 238 and 146 r. p. m. are procured.

ROLL CHART — No. 626 MACHINE, Page 82

Where Stock Numbers of Spacing Collars and Gauges differ be sure to specify additional Spacing Collars and Gauges depending on assortment of Rolls required.

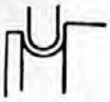
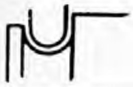
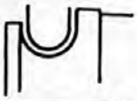
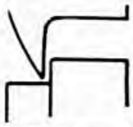
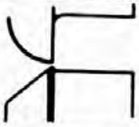
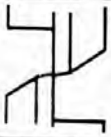
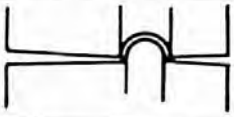
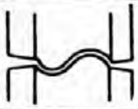
	Name of Rolls	Stock Part No.	Stock Part No. of Spacing Collars	Gauge Used Part No.	Capacity
	⅛" Turning Rolls $4.00 Pair	Upper No. 2562 Lower No. 2563	Two of Stock Part 2578 $2.00 Pair	Stock Part 2588 $3.00	No. 18 Gauge
	¼" Turning Rolls $4.00 Pair	Upper No. 2564 Lower No. 2565	Two of Stock Part 2578 $2.00 Pair	Stock Part 2588 $3.00	No. 18 Gauge
	3/16" Turning Rolls $4.00 Pair	Upper No. 2566 Lower No. 2567	Two of Stock Part 2578 $2.00 Pair	Stock Part 2588 $3.00	No. 18 Gauge
	Burring Rolls $4.00 Pair	Upper No. 2568 Lower No. 2569	Two of Stock Part 2578 $2.00 Pair	Stock Part 2588 $3.00	Up to 3/16" Flange No. 18 Gauge
	Wiring Rolls $4.00 Pair	Upper No. 2570 Lower No. 2571	Two of Stock Part 2578 $2.00 Pair	Stock Part 2588 $3.00	Up to 3/16" Wire No. 18 Gauge
	Slitting Cutters $8.00 Pair	Upper and Lower Stock Part 2583	Two of Stock Part 2584 $2.00 Pair	Stock Part 2588 $3.00	No. 16 Gauge
	⅜" Single Bead Roll $6.00 Pair	Upper No. 2603 Lower No. 2604	Two of Stock Part 2579 $2.00 Pair	Stock Part 2588 $3.00	No. 18 Gauge
	Ogee Rolls $6.00 Pair	Upper No. 2576 Lower No. 2577	Two of Stock Part 2578 $2.00 Pair	Stock Part 2588 $3.00	No. 18 Gauge

For combined Crimping and Beading only with Ogee Beading Rolls Spacing Collars are not needed. Write for Prices on Single Beading and Crimping Rolls. (Special).

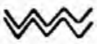
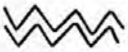
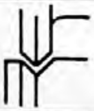
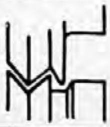
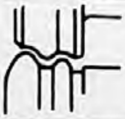
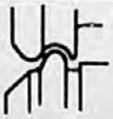
	¼" Pitch Crimping Rolls $6.00 Pair	Upper No. 2572 Lower No. 2573	Two of Stock Part 2579 $2.00 Pair	Stock Part 2582 $2.50	No. 20 Gauge
	3/16" Pitch Crimping Rolls $6.00 Pair	Upper No. 2574 Lower No. 2575	Two of Stock Part 2579 $2.00 Pair	Stock Part 2582 $2.50	No. 18 Gauge
	No. 1 Elbow Rolls $4.00 Pair	Upper No. 2595 Lower No. 2596	Two of Stock Part 2578 $2.00 Pair	Curved Apron Gauge Stock Part 2605 $8.00	No. 18 Gauge
	No. 2 Elbow Rolls	Special on Application	Two of Stock Part 2578 $2.00 Pair	Curved Apron Gauge Stock Part 2605 $8.00	
	No. 9 Elbow Rolls	Special on Application	Two of Stock Part 2578 $2.00 Pair	Curved Apron Gauge Stock Part 2605 $8.00	
	No. 10 Elbow Rolls	Special on Application	Two of Stock Part 2578 $2.00 Pair	Curved Apron Gauge Stock Part 2605 $8.00	

ROLL CHART — No. 627 MACHINE, Page 82

Where Stock Numbers of Spacing Collars and Gauges differ be sure to specify additional Spacing Collars and Gauges depending on assortment of Rolls required.

	Name of Rolls	Stock Part No.	Stock Part No. of Spacing Collars	Gauge Used Part No.	Capacity
	3/16" Turning Rolls $6.00 Pair	Upper No. 2473 Lower No. 2474	Two of Stock Part 2489 $3.00 Pair	Stock Part 2491 $4.00	**No. 16 Gauge**
	¼" Turning Rolls $6.00 Pair	Upper No. 2475 Lower No. 2476	Two of Stock Part 2489 $3.00 Pair	Stock Part 2491 $4.00	**No. 16 Gauge**
	5/16" Turning Rolls $6.00 Pair	Upper No. 2477 Lower No. 2478	Two of Stock Part 2489 $3.00 Pair	Stock Part 2491 $4.00	**No. 16 Gauge**
	Burring Rolls $6.00 Pair	Upper No. 2479 Lower No. 2480	Two of Stock Part 2489 $3.00 Pair	Stock Part 2491 $4.00	**Up to 3/16" Flange No. 16 Gauge**
	Wiring Rolls $6.00 Pair	Upper No. 2481 Lower No. 2482	Two of Stock Part 2489 $3.00 Pair	Stock Part 2491 $4.00	**Up to 5/16" Wire No. 16 Gauge**
	Slitting Cutters $10.00 Pair	Upper and Lower Stock Part 2495	Two of Stock Part 2496 $3.00 Pair	Stock Part 2491 $4.00	No. 14 Gauge
	⅝" Single Bead Roll $9.00 Pair	Upper No. 2614 Lower No. 2615	Two of Stock Part 2490 $3.00 Pair	Stock Part 2491 $4.00	No. 16 Gauge
	Ogee Bead Rolls $9.00 Pair	Upper No. 2487 Lower No. 2488	Two of Stock Part 2489 $3.00 Pair	Stock Part 2491 $4.00	No. 16 Gauge

For combined Crimping and Beading only with Ogee Beading Rolls Spacing Collars are not needed. Write for Prices on Single Beading and Crimping Rolls. (Special).

	¼" Pitch Crimping Rolls $9.00 Pair	Upper No. 2485 Lower No. 2486	Two of Stock Part 2490 $3.00 Pair	*Stock Part 2493 $3.00 See Foot Note	No. 18 Gauge
	5/16" Pitch Crimping Rolls $9.00 Pair	Upper No. 2483 Lower No. 2484	Two of Stock Part 2490 $3.00 Pair	*Stock Part 2493 $3.00 See Foot Note	No. 16 Gauge
	No. 1 Elbow Rolls $10.00 Pair	Upper No. 2606 Lower No. 2607	Two of Stock Part 2489 $3.00 Pair	Curved Apron Gauge Stock Part 2616 $9.00	**No. 16 Gauge**
	No. 2 Elbow Rolls	Special on Application	Two of Stock Part 2489 $3.00 Pair	Curved Apron Gauge Stock Part 2616 $9.00	
	No. 9 Elbow Rolls	Special on Application	Two of Stock Part 2489 $3.00 Pair	Curved Apron Gauge Stock Part 2616 $9.00	
	No. 10 Elbow Rolls	Special on Application	Two of Stock Part 2489 $3.00 Pair	Curved Apron Gauge Stock Part 2616 $9.00	

*When ordering Crimp Rolls Gauges 2491 and 2493 must be used together.

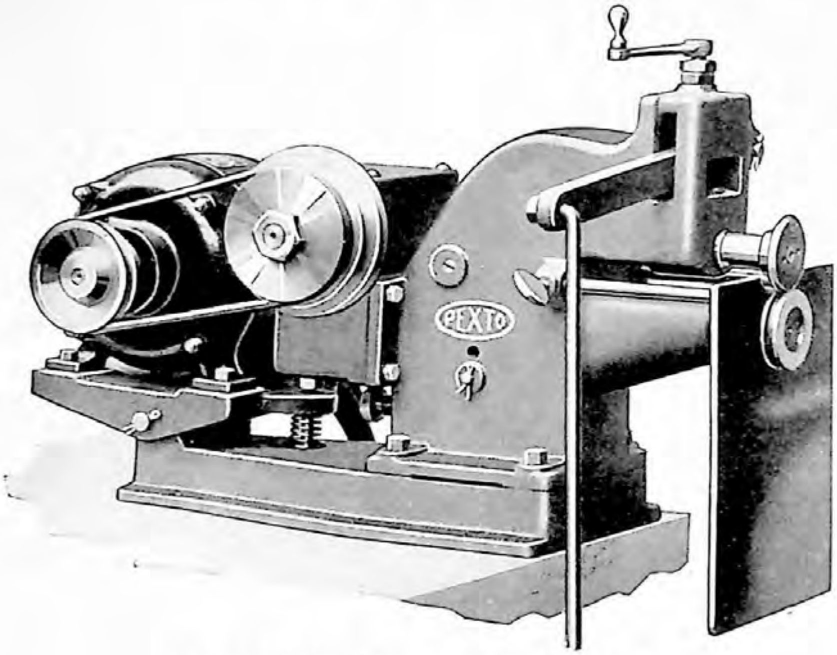
THE UNIVERSAL ELECTRIC ROTARY MACHINE No. 623

CAPACITY

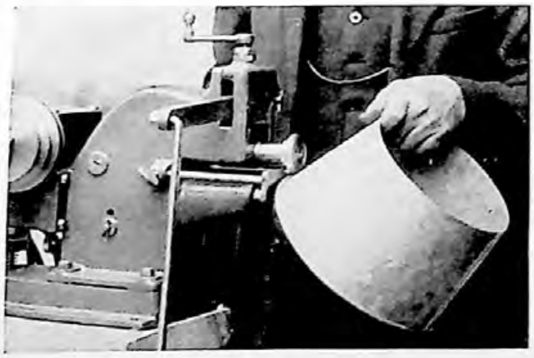
No. 22 Gauge for Turning, Wiring, Burring, Beading and Elbow Edging.

No. 24 Gauge for Plain Crimping.

No. 20 Gauge for Slitting and Trimming.



Weight, 105 lbs. Length, 23 inches.
Width, 14 inches. Height, 16 inches.



Depth of Throat, 4 inches.
Distance between Shaft Centers, 2 inches.

A little machine that can be furnished with the same variety of Rolls and which enjoys the same advantages as the "Speed King" excepting that it is only supplied with Single Clutch. Speed of Roll Shafts through Step Cone Pulley is 50 and 75 R. P. M. Furnished with Open and Crossed Belt for Forward or Reverse Drives. Friction Clutch is operated by Foot Pedal or Hand Lever.

A Toggle Switch is mounted on the machine within reach of the operator and is effectively used for instantaneous starting and stopping of the Rolls.

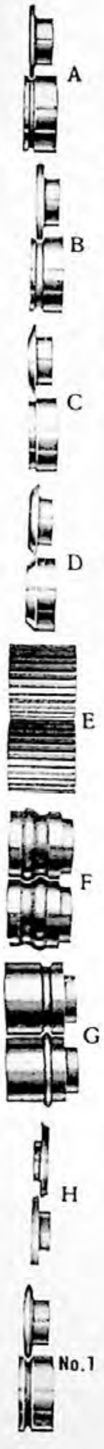
Intended for light work and to fill the requirements for a Motor Driven Rotary Machine — priced somewhat lower than the "Speed King".

Furnished with 1/4 H. P. Motor, Single Phase, 60 Cycle, 110/220 Volts and ten feet of Cord and Plug.

Furnished with Rolls and Gauges as specified — Floor Pedestal extra.
See Rolls and Gauges on page

ROLL CHART — No. 623 MACHINE

Illustration of Machine and Specifications see Page 86



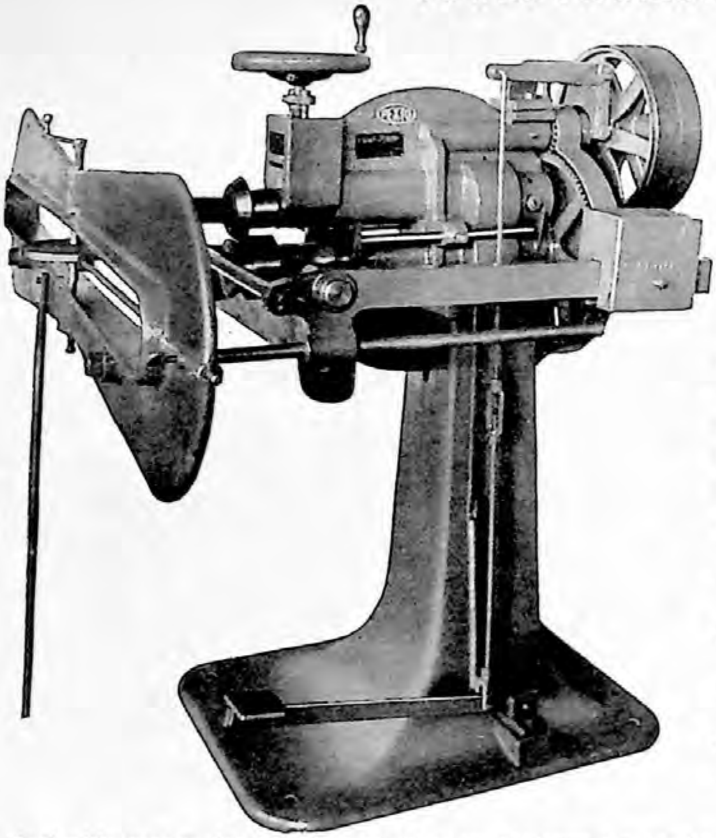
The Production and the Tinware and Sheet Metal Products manufacturer will find it more economical to set up several of these machines for individual operations while the jobbing shop through the interchangeability of Rolls will find that this machine will do the same work of many, quicker and easier.

HOW TO ORDER STANDARD ROLLS AND GAUGES.

All Rolls are countersunk and held to shafts with screw nuts, making the locking of gears to remove rolls unnecessary. Rolls are slotted to fit Keyway shafts to prevent roll slippage and for making the frequent changing of rolls easy. **ORDER ROLLS AND GAUGES ACCORDING TO THEIR OWN STOCK NUMBERS.**

	Stock No. of Rolls	Name of Rolls		Stock Numbers of Corresponding Gauges
A	2332 2333	Thin Upper Turning Roll Thin Lower Turning Roll *Largest Wire No. 11 Gauge*	$2.00 pair	$3.00 each Gauge 2440
B	2334 2335	Thick Upper Turning Roll Thick Lower Turning Roll *Largest Wire No. 7 Gauge*	2.00 pair	
C	2336 2337	Upper Burring Roll Lower Burring Roll	2.00 pair	Gauge 2441
D	2338 2339	Upper Wiring Roll Lower Wiring Roll *Largest Wire No. 7 Gauge*	2.00 pair	
E	2447 2448	Upper Straight Crimp Roll Lower Straight Crimp Roll	4.00 pair	Gauge 2442
F	2443 2444	Upper Ogee Beading Roll ¾ inch Lower Ogee Beading Roll ¾ inch	4.00 pair	Gauge 2440 or 2441
G	2450 2451	Upper Single Bead Roll ¼ inch Lower Single Bead Roll ¼ inch	4.00 pair	
H	2445 2446	Upper Trimming or Slitting Cutter Lower Trimming or Slitting Cutter	6.00 pair	
No. 1	2343 2344	Upper No. 1-V Elbow Edging Roll Lower No. 1-V Elbow Edging Roll	2.00 pair	Gauge 2440

POWER FLANGING MACHINES



Capacity — Flanges ⅝ inch high No. 22 Gauge; ¾ inch on 20; ⅞ inch on 18; or 1 inch on 16 and 1¼ inch on 14 Gauge Iron, one pair Rolls for each size of Flange must be used.

	T&L Pulleys	**T&L Pulleys**
Number	**633**	**634**
Will flange Bottoms ....dia. in.	12 to 30	12 to 50
Diameter of Rolls..............................in.	4½	4½
Ratio of Gearing	4½:1	4½:1
Horse Power Required ............H.P.	3	3
Speed of Motor ........................R.P.M.	1200	1200
Diameter of Pulleys ....in.	16	16
Depth of Throat ....in.	10½	10½
With Turning and Wiring Rolls Wire may be used up to......in.	½	½
Shipped usually crated. Flanging Attachment boxed		
Shipping Weight ....approx. lbs.	1000	1100

NOTE: — Regular equipment includes Tight and Loose Pulleys. When preferred can arrange with Treadle operated Friction Clutch Attachment for Belt Drive as illustrated or with Direct Motor Drive.

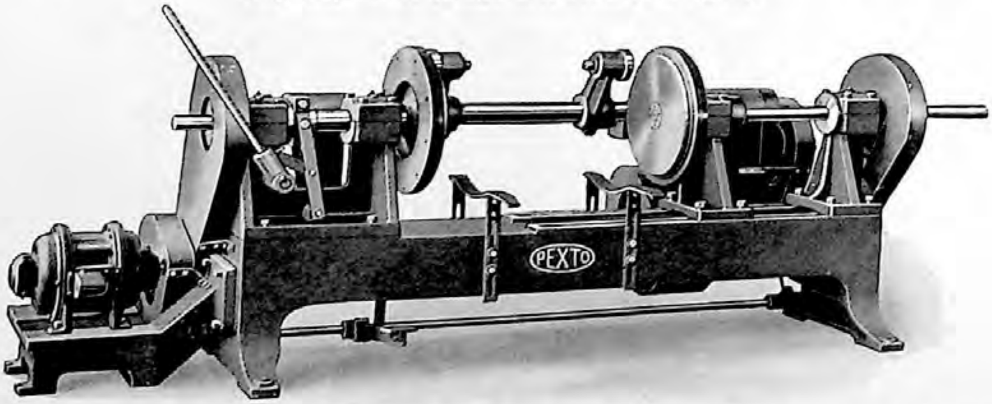
A desirable means for flanging of discs or bottoms for tanks. Removing the flanging attachment and the proper rolls substituted, a serviceable, rigid machine is secured for producing beading, turning, wiring and flanging operations in cylinderical bodies.

Round discs to be flanged are centered and held in the yoke on the counter-balanced swiveled arm. The yoke is gradually raised until the flange is turned as far as desired, but not to exceed right angles. The obtainable height of the flange depends upon the thickness of stock to be used and the expectations as to smoothness of flanges. One pair of flanging rolls will not throw a flange in various heights, extra rolls being required, depending on the variations in the height of flanges to be turned.

When ordered with friction clutch attachment, this attachment is operated through a foot treadle for instantaneous stopping and starting of the rolls.

No. 1112 POWER DOUBLE END FLANGING MACHINE

Capacity — 18 gauge soft steel and lighter



This machine has been designed principally for simultaneous flanging of the both ends of steel drum bodies. It can be arranged belt or motor drive for maximum diameter of bodies 24 ins. For maximum height of bodies 38 ins. Speed of drive shaft R.P.M. 300. Speed of chucks 130 R.P.M. Size of pulley 12 x 4 ins. One set of chucks required for each diameter of drum but a slight ½ inch variation will not influence chuck changes. Requires 3 H.P. 1200 R.P.M. Weight approx. lbs. 3500.

Bulletin N-35

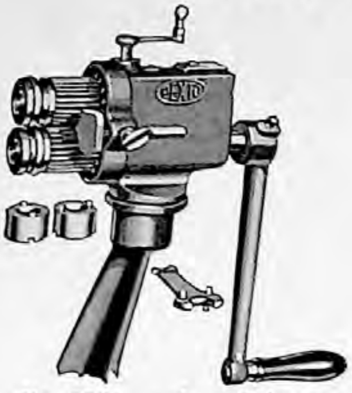
BEADING - CRIMPING DOUBLE SEAMING AND SEAM CLOSING MACHINES

POWER AND HAND DRIVES

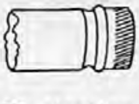
THE PECK, STOW & WILCOX CO. **SOUTHINGTON, CONN.**

"Our Second Century"

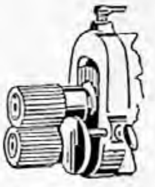
INTERCHANGEABLE CRIMPING AND BEADING MACHINES



No. 0581 — As a Crimper and Beader (Capacity—24 gauge)



Illustrating pipe with crimp and bead



As a Plain Crimper

Number	Spiral Crimp 581	Straight Crimp 0581
Capacity soft steel ... gauge	24	24
Width crimping rolls ... ins.	1 ¾	1 ¾
Width beading rolls ... ins.	1	1
Diameter beading rolls ... ins.	1 15/16	1 15/16
Diameter crimping rolls ... ins.	1 13/16	1 13/16
Size ogee bead ... ins.	½	½
Shipped boxed regularly ... approx. lbs.	30	30

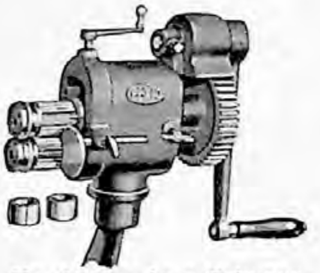
Designed for serving the requirements of the large or small sheet metal shop and an inexpensive desirable addition to the stove pipe department of the hardware store.

Frame is one piece. Enclosed gears are steel machine cut. Beading and crimping rolls are countersunk and held on arbors with round nuts which leave the face of rolls flush with arbors.

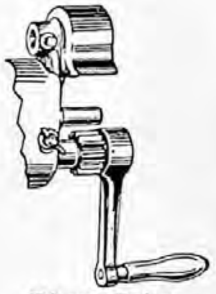
A pair of steel blank collars accompany each machine and when these collars are substituted for beading rolls, same machine is converted into a plain crimping machine.

Adjustment is provided for changing slightly the relative depth of crimp.

No. 975 Bench Standard furnished.



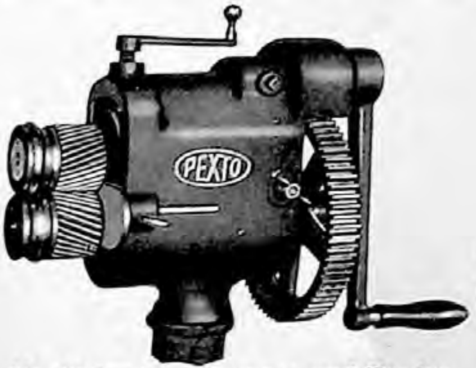
No. 0585—As a Crimper and Beader (Capacity—20 gauge)



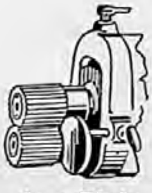
Direct Drive

Number	Straight Crimp 0585	Spiral Crimp 585
Capacity soft steel ... gauge	20	20
Diameter beading roll ... ins.	1 15/16	1 15/16
Diameter crimping roll ... ins.	1 13/16	1 13/16
Width crimp rolls ... ins.	1 ¾	1 ¾
Width bead rolls ... ins.	1	1
Size ogee bead ... ins.	½	½
Ratio gearing ...	3:1	3:1
Distance between shaft centers ... ins.	1 ¾	1 ¾
Shipped boxed regularly ... weight approx. lbs.	65	65

A very practical feature is offered in the arrangement of the driving gears. Two speeds are provided for; back-geared for heavy stock and direct drive when lighter gauges of materials are used. The driving gear can be removed and the machine converted instantly into a direct acting crimper by attaching the crank to lower shaft. Connecting gears are of machine cut steel; the frame and cap machined to insure perfect fit of all working parts for accurate and uniform work. Rolls are made of a high-grade steel, scientifically hardened, and the gauge is of extra wide proportions made from tool steel properly hardened. Adjustments are provided for regulating the relative depth of crimp and bead. The adjustment will be found in a wedge between the rear bearings. This wedge is adjusted by wing nuts in front and back of frame near handle end. The upper shaft can be tipped toward front or back, as desired, thus making a deep crimp and shallow bead, or shallow crimp and deep bead. Face of rolls are flush with their arbors. When the blank rolls as furnished are placed behind the crimping rolls a plain crimper is procured. Always be sure that slighty tapered crimping roll is on upper shaft. No. 975 Standard furnished.



No. 601—As a Crimper and Beader (Capacity—18 gauge)



As a Plain Crimper

Number	Straight Crimp 0601	Spiral Crimp 601
Capacity soft steel and lighter ... gauge	18	18
Diameter beading rolls ... ins.	2 13/16	2 13/16
Diameter crimping rolls ... ins.	2 11/16	2 11/16
Width crimping rolls ... ins.	1 ¾	1 ¾
Width beading rolls ... ins.	1 ¼	1 ¼
Size ogee bead ... ins.	⅞	⅞
Ratio of gearing ...	4 ½:1	4 ½:1
Distance between shaft centers ... ins.	2 ⅝	2 ⅝
Shipped boxed regularly ... weight approx. lbs.	125	125

This interchangeable machine is designed for heavy duty. Adjustments are provided for regulating the relative depth of crimp and bead. This adjustment will be found in a wedge between the rear bearings. This wedge is adjusted by wing nuts in front and back of frame near handle end. The upper shaft can be tipped toward front or back, as desired, thus making a deep crimp and shallow bead, or shallow crimp and deep bead. The gearing is so arranged for allowing the position of the crank to be changed for carrying the work either toward or from the operator with the crank always moving in one direction from the operator — an exclusive Pexto feature. Always be sure that slightly tapered crimping roll is on upper shaft. One pair blank rolls to replace beading rolls only are furnished, when placed behind the crimping rolls a plain crimper is procured. Furnished with extra heavy Standard No. 977.

POWER CRIMPING AND BEADING MACHINES

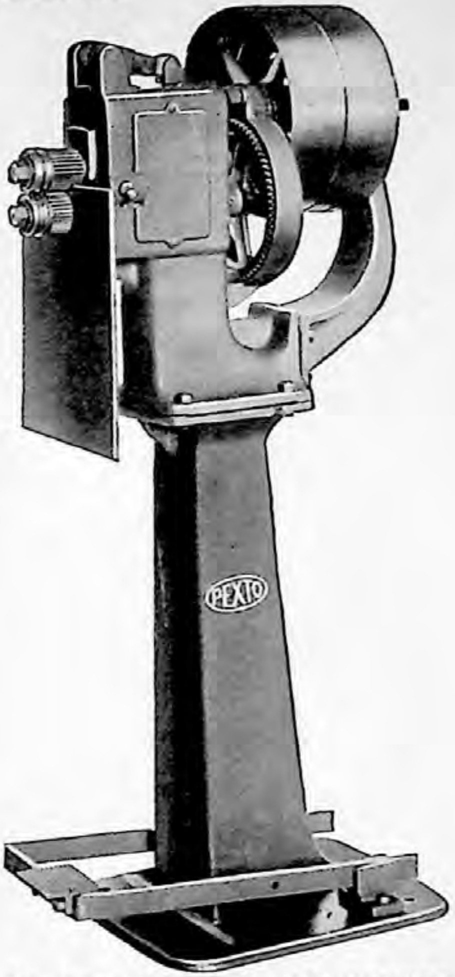
A high production machine for crimping and beading or for crimping only. Rolls are keyed to arbors and secured with round nuts leaving face of rolls flush. Frames are of one piece construction for rigidity. Pinions are steel and large gear is semi-steel machine cut. All gears are enclosed. The main bearings are bronze bushed. The upper roll is depressed by means of a foot treadle attachment but at extra cost can be arranged with crank screw for depressing upper roll. All working parts are of a quality and so proportioned as to give long life under the test of consant use.

Number	With T & L Pulleys 0673	With T & L Pulleys 0689
Capacity soft steel ....gauge No.	24	22
Diameter beading rolls ....ins.	1 15/16	2 ½
Diameter crimping rolls ....ins.	1 13/16	2 ⅜
Width beading rolls ....ins.	1	1
Width crimping rolls ....ins.	1 ¾	1 ¾
Size ogee bead ....ins.	½	9/16
Distance between shaft centers............ins.	1 ¾	2 ¼
Ratio of gearing	2:1	4:1
Size of pulleys ....ins.	12x3	12x3
Speed of pulleys ....r.p.m.	200	300
Speed of rolls ....r.p.m.	100	75
Shipped boxed, without pedestal ....approx. lbs.	150	260
Shipped crated, with pedestal ....approx. lbs.	250	360

NOTE:—Furnished regularly with straight crimping rolls. At no extra cost spiral crimping rolls will be substituted for straight crimping rolls and when so required specify as No. 673 or 689.

One pair blank collars to substitute for beading rolls for crimping only are always included.

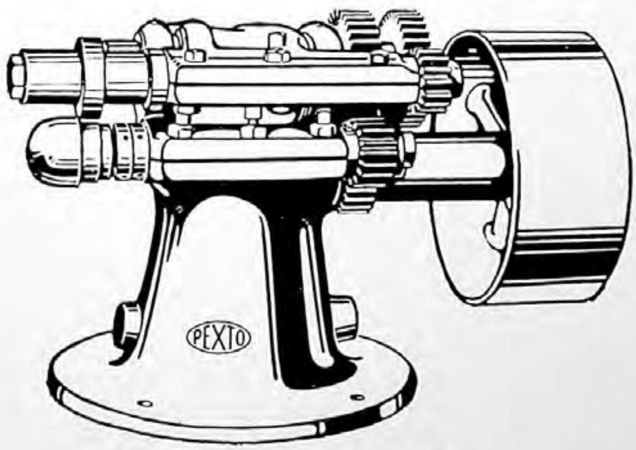
Furnished with or without floor pedestal. Apron gauge and rolls are included.



No. 0689 CRIMPER AND BEADER
(Capacity—No. 22 gauge soft steel)

PARALLEL SHAFT BEADING MACHINE

A light compact Parallel Shaft Beading and Flanging Machine for work on which a tilting top arbor would be objectionable, with arrangement of gearing as provided, it is possible on power machines to apply lower rolls approximately 1 ¼ inches minimum diameter. In such cases a correspondingly larger upper roll and gear ratio is required, with minimum 2 inch distance between shaft centers when rolls are closed, maximum distance between shaft centers when rolls are open 3 ⅜ inches. Prices will be quoted on receipt of detailed information on work contemplated. Upper roll is depressed by foot treadle. Bearings are bronze bushed. Can furnish belt driven machine without pedestal for bench use.

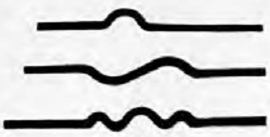


No. 1630 BEADING MACHINE
Direct motor drive is thru silent chain and sprocket

Number	Hand 630	Tight Pulley 1630	Motor Drive 2630
Dia. of arbors in bearings min. ins.	1	1	1
Diameter of arbor extensions ins.	1	1	1
Center distance between arbors .... min. ins.	2	2	2
Center distance between arbors .... max. ins.	3 ⅜	3 ⅜	3 ⅜
Lgth. of reg. arbor extension ins.	1 ½	1 ½	1 ½
Length of arbor extension can be altered to suit requirements			
Ratio of gearing............	2:1	2:1	2:1
Motor requirements			½ h.p., 900 rpm
Size pulleys ....ins.		8x2	
Speed of pulleys ....r.p.m.		150	
Shipping weight with pedestal .... approx. lbs.	340	355	400

BEADING MACHINES

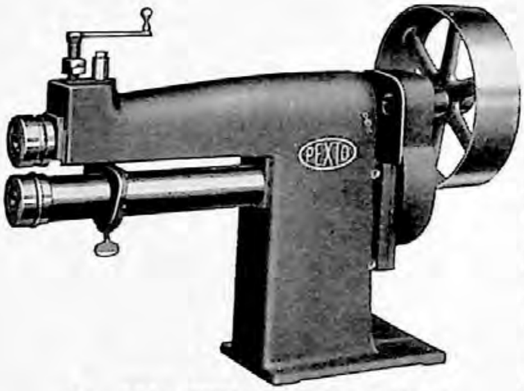
BEADING MACHINE
For ornamenting and stiffening sheet metal bodies.



"A"—Single bead.

"B"—Ogee bead.

"C"—Triple bead and a variety of other special beading rolls can be furnished.



No. 1617 BEADING MACHINE
(Capacity—No. 16 gauge soft steel)

Many unusual design features are embodied in the construction of these machines for utility and strength.

Frame is one piece. Horn is of rigid construction. Bearings for upper and lower arbors are bronze bushed. Pinions are steel and driving gear is semi-steel machine cut. All gears are fully enclosed. The hand machine or when fitted with pulley are for bench use but floor pedestal can be fitted at extra cost. Motor driven machines are invariably furnished with floor pedestal of welded steel construction.

Motor drive—When arranged for motor drive single friction clutch for driving rolls in one direction is included invariably. Silent chain drive is applied from the motor to the drive shaft. Three sizes of interchangeable sprockets for the drive shaft are included for obtaining range of roll speeds 22, 35 and 44 r. p. m. Operation of clutch is by hand or by foot treadle.

Can furnish motor driven machine with double friction clutch for forward and reverse drive.

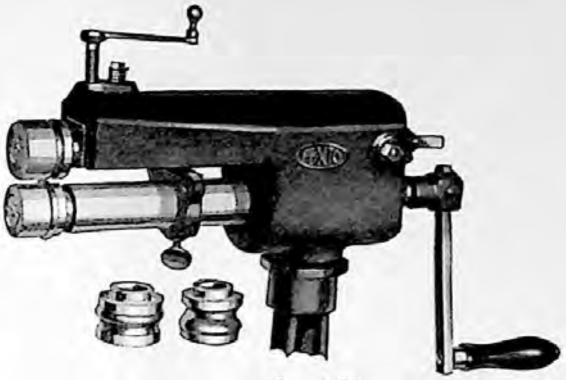
Number		Hand 0617	Tight Pulley 1617	Silent Chain Motor Drive with Single Friction Clutch 3617
Capacity	gauge	18	16	16
Depth of throat to frame	ins.	13	13	13
Depth of throat to gauge	ins.	12¼	12¼	12¼
Distance between shaft centers	ins.	3	3	3
Diameter of shaft in bearings	ins.	1½	1½	1½
Diameter of rolls	ins.	3 3/16	3 3/16	3 3/16
Width of rolls	ins.	1¾	1¾	1¾
Ratio of gearing	ins.	3½:1	3½:1	3½:1
Size of pulley	ins.	....	12x3	....
Speed of pulley	r.p.m.	....	140	....
Speed of rolls	r.p.m.	....	40	22-35-44
Speed of rolls in feet per minute		....	31	17-27-34
Horse power required	h.p.	....	....	¾
Speed of motor	r.p.m.	....	....	1800
Shipped boxed without pedestal	approx. lbs.	175	190	350
Shipped crated with pedestal	approx. lbs.	275	290	450

NOTE:—Furnished regularly with one pair each single bead rolls ⅜ inch and 1 inch ogee. Circular cutters with sleeves and straight crimping rolls and guide rests for supporting long length cylinders can be furnished when required at extra cost. Three sizes of interchangeable sprockets for drive shaft are included with No. 3617 motor driven machine. The drive and gear box is the same as applies to No. 627 Electric Rotary Machines page 82.

BEADING MACHINES

Number	Hand 620	Hand 619
Capacity ......gauge	24	20
Depth throat to frame ......ins.	7	7½
Depth throat to gauge ......ins.	6	6¾
Distance between shaft centers ......ins.	2	2¼
Diameter rolls ......ins.	1 15/16	2⅜
Width rolls ......ins.	1¾	1⅝
Ratio of gearing	......	2½ to 1
Size single bead in rolls ......ins.	¼	5/16
Size ogee bead in rolls ......ins.	¾	⅞
Shipped boxed regularly, weight approx. lbs.	55	110

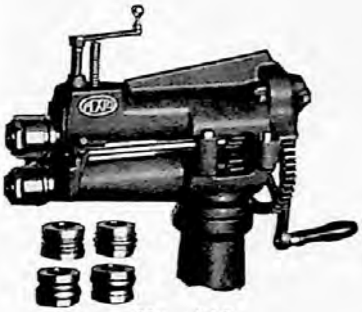
NOTE:—Bench standards are furnished regularly. Two pairs beading rolls are included. Straight crimping rolls can be furnished at extra cost. A guide rest for supporting long work can be furnished at extra cost.



No. 620

No. 620 is a universally popular machine greatly improved and will perform well up to rated capacity. A rigid solid frame is employed with arbors and gears fully enclosed. Lower arbor bearings are bronze bushed. An adjustable steel crank that can be attached to the upper or lower shaft for driving rolls toward or from the operator is provided. Gears are steel machine cut. Arbors are key seated to prevent roll slippage and rolls are countersunk and held to their arbors with round nuts.

No. 619—This is a shallow throat machine of capacity heavier than No. 620 but in its construction a frame and a cap is employed of strength for beading up to capacity. Pinions are steel and large gear is semi-steel machine cut.

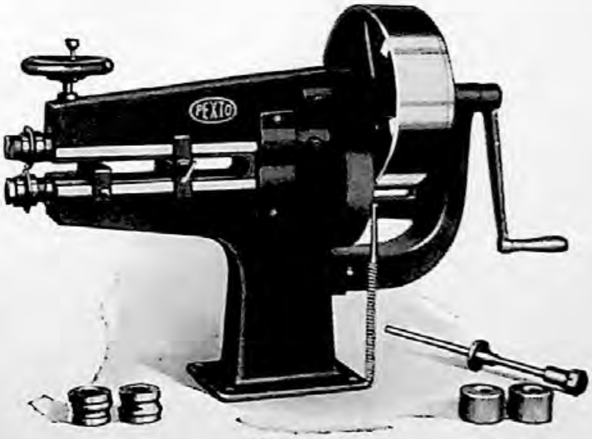


No. 619

INTERCHANGEABLE BEADING MACHINE

Number	Hand 631	Tight Pulley 632	Clutch Pulley 628
Capacity ......gauge	16	16	16
Depth throat ......ins.	11	11	11
Ratio gearing	3 to 1	3 to 1	3 to 1
Diameter beading rolls ......ins.	2¾	2¾	2¾
Size of pulleys ......ins.	......	3x12	3x12
Shipped boxed regularly ......weight approx. lbs.	210	235	260

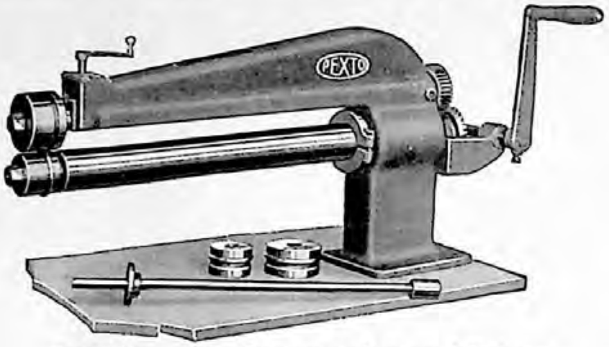
NOTE:—Furnished regularly with one pair single rolls ⅜-inch and 1 inch ogee bead. Straight crimping rolls, cutters and collars and guide rest can be furnished at extra cost. Floor pedestal can be furnished at extra cost.



No. 628

The frame and base of this machine is a solid casting and the gearing and arbors are enclosed. A stay clamp is provided to eliminate any spring in frame when working up to capacity. Gearing is so arranged for allowing position of the crank to be changed for carrying the work either toward or from the operator with the crank always moving in one direction from the operator. Pinions are steel and large gear is semi-steel machine cut.

DEEP THROAT BEADING MACHINE



Capacity — No. 20 gauge iron and lighter

Number		Hand 0664
Diameter lower roll	ins.	3 7/16
Width rolls	ins.	2 ½
Depth throat	ins.	28
Size single bead in rolls	ins.	⅜
Size ogee bead in rolls	ins.	1
Shipped crated regularly	weight approx. lbs.	420

NOTE:—Can be furnished with tight or tight and loose pulleys when so ordered. One pair each single and ogee beading rolls are furnished. Special rolls to order. When specified, guide rest for supporting work can be furnished at extra cost. Can be arranged direct motor drive and when so arranged single clutch silent chain motor drive as pages 82 and 83 is applied.

FURNACE PIPE SEAMER — No. 664

This machine as made from the above patterns and fitted with proper rolls will join the circular joints of tin furnace pipe and produces a joint which is perfect in tightness and appearance. To joint pipe sections by beading the telescoping pipe ends, suitable rolls can be furnished and are usually made with single bead ¼-inch wide.

For the manufacturer we recommend this machine arranged with tight and loose pulleys or direct motor drive.

MOTOR DRIVEN EXTRA DEEP THROAT BEADING MACHINE

Capacity — No. 18 gauge soft steel and lighter

Number		Silent chain motor drive with double friction clutch 629
Depth of throat from center of rolls to frame	ins.	35 ½
Depth of throat from center of rolls to gauge	ins.	34 ¾
Center distance between shafts	ins.	4 5/16
For work in diameter as small as	ins.	4 ½
Diameter of arbor in bearings	ins.	1 ¾
Diameter of arbor extension for rolls regular	ins.	3 ¼
Speed of rolls	r.p.m.	22-35-44
Speed of rolls—feet per minute		25-40-50
Horse power required	h.p.	¾
Speed of motor	r.p.m.	1800
Shipped crated	approx. lbs.	750

NOTE:—Can be furnished with cutters and collars for slitting soft steel full depth of throat capacity 16 gauge. Can also be supplied with special depth of throat on which prices will be quoted on receipt of specifications.

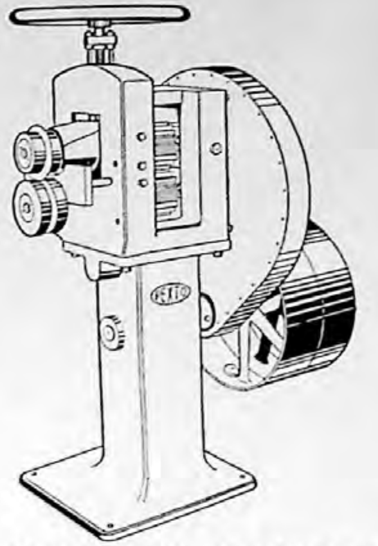
Of welded steel construction with bronze bushed bearings. Alemite system for lubrication is employed. Arranged motor drive the drive from the motor is obtained through silent chain drive with three speed changes by means of interchangeable sprockets which are included. Furnished with double friction clutch which is totally enclosed in gear box running completely immersed in oil. When so required single friction clutch for driving rolls only in one direction can be applied. Photographic blue print will be furnished on request.

POWER BEADING AND FLANGING MACHINES

Number		610
Capacity—soft steel and lighter	ins.	⅛
Diameter rolls	ins.	5½
Width of rolls	ins.	3
Center distance of shafts	ins.	5
Distance from end of shaft to frame	ins.	7
Size of pulleys	ins.	20x5
Ratio of gearing		7:1
Horse power required	h.p.	3 to 5
Speed of motor	r.p.m.	1200
Speed of pulleys	r.p.m.	200
Shipped reguarly on skids	approx. lbs.	1275

NOTE:—Furnished with tight and loose pulleys regularly. Friction clutch and direct motor attachments are extra. Furnished regularly without rolls. Rolls are made special to order. Size of motor when required direct motor drive is from 3 to 5 h. p. depending upon the kind of work to be done. Extension to lower arbors for supporting work can be furnished at extra charge.

An extra heavy beading machine for such work where a deep throat is not required. With the proper rolls it will perform a variety of operations on heavy steel. Compact and durable.



Heavy Duty Beading Machine No. 610 (Capacity—⅛" soft steel and lighter)

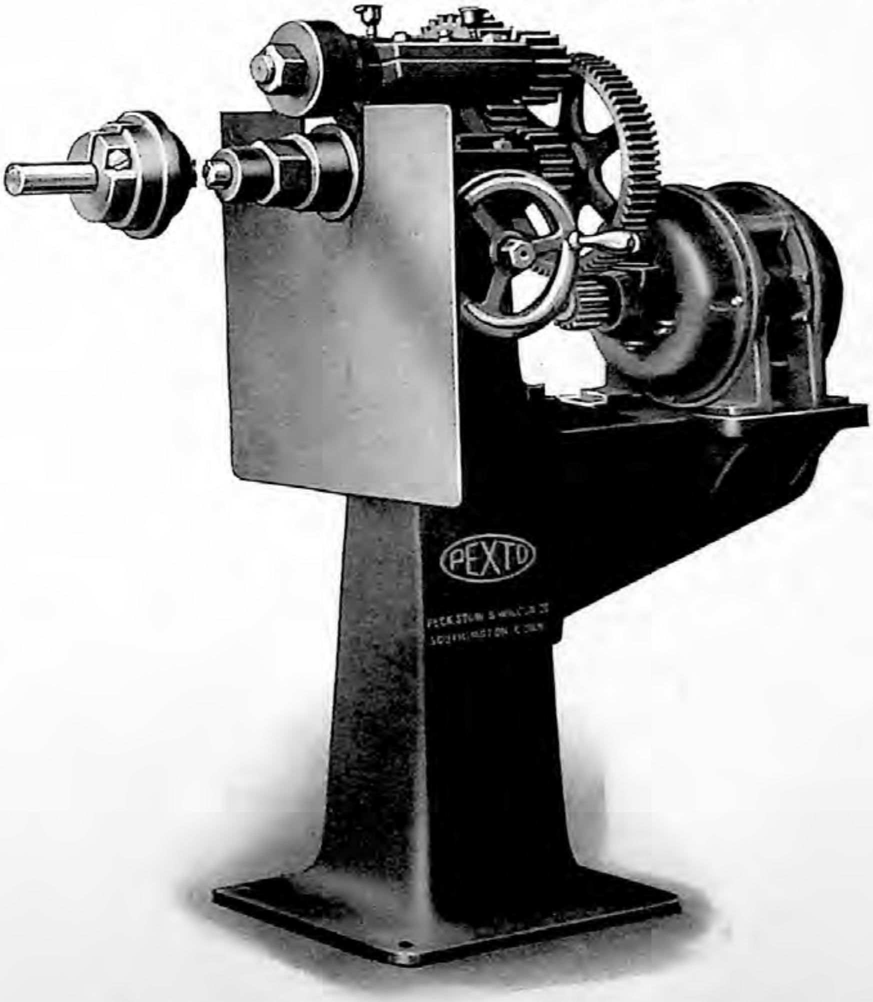
Designed principally for beading, corrugating and flanging — with the proper rolls a machine of this construction is indispensable for accomplishing a variety of operations.

The upper shaft swings parallel to the lower one and is brought down by means of a hand wheel and screw acting on a lever at the back of the machine. At an extra charge automatic cam attachment for bringing down upper shaft can be applied to No. 625.

The capacity will depend upon the shape and size rolls to be used.

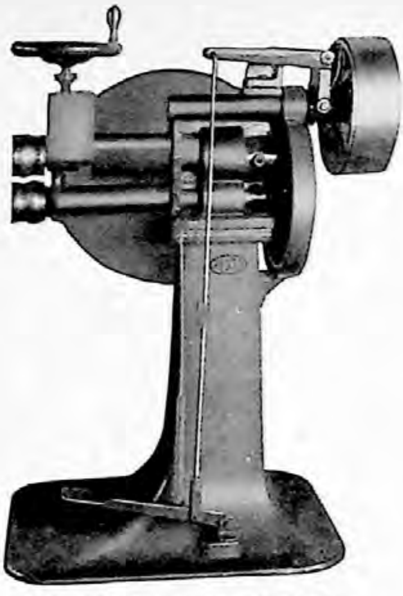
Number	624	625
Length of arbor extension for rolls ins.	3	15½
Standard distance between shaft centers ins.	4½	6
Diameter of shafts ins.	1¾	2⅞
Size tight and loose pulleys ins.	12x3¼	24x4¼
Speed of pulleys r.p.m.	150	500
Ratio of gearing	....	4:1
Horse power required approx. h. p.	1	3
Speed of motor r.p.m.	900	1200
Shipped regularly on skids approx. lbs.	700	1600

NOTE:—Furnished with bronze bushed bearings. Can be built with short or extended shafts. Apron gauge is regular. Tilting apron gauge can be furnished special. Furnished regularly with tight and loose pulleys. Direct connected motor attachment is extra. Rolls are made special depending upon width and style of work required. Extension to lower shaft is extra.



No. 624 Single End Power Flanging and Beading Machine (Capacity depends on type rolls to be used) Illustration of 625 Machine on Page 89

POWER BEADING MACHINES

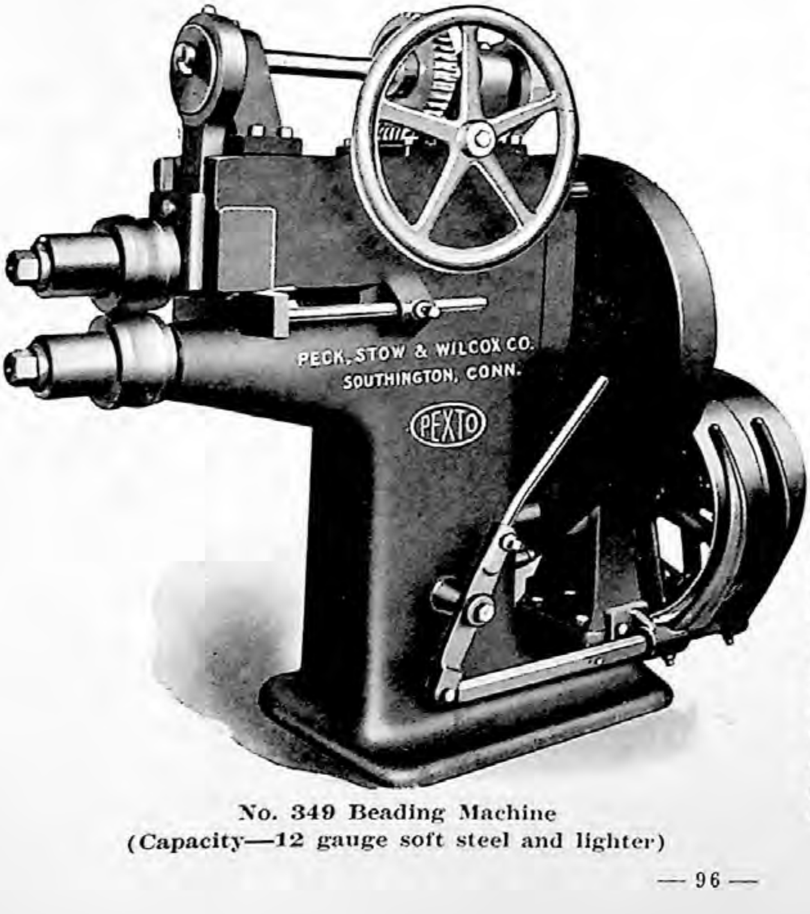


No. 0612 Beading Machine
(Capacity—14 gauge soft steel)

Number	Clutch 0612	T & L Pulleys 612
Capacity soft steel gauge No.	14	14
Depth throat to frame ins.	12	12
Depth throat to gauge ins.	10¼	10¼
Diameter Rolls ins.	4 7/16	4 7/16
Width rolls ins.	3	3
Size ogee bead ins.	2	2
Distance between shaft centers ins.	4	4
Size pulleys ins.	14x4	16x3
Speed of pulleys r.p.m.	90	90
Ratio of gearing	4½:1	4½:1
Horse power required h.p.	2 to 3	2 to 3
Speed of motor r.p.m.	1200	1200
Shipped crated regularly weight approx. lbs.	750	745

NOTE:—No. 612 is constructed for power and fitted with tight and loose pulleys and belt shifter. No. 0612 has pulley friction clutch attachment. Ogee beading rolls are furnished regularly. Rolls in other shapes will be furnished only when specified and at an extra cost. Can be arranged direct motor drive. Motor attachments are extra. We furnish these machines with hand wheel for hand use. Extension to lower arbor and collar for supporting cylinders can be furnished at an extra charge.

Patterns No. 612 offer an inexpensive rigid heavy duty machine for beading and special operations when fitted with the required rolls. Small driving gears and pinions are steel and large driving gear is semi-steel machine cut.



No. 349 Beading Machine
(Capacity—12 gauge soft steel and lighter)

Number	348	349
Depth throat ins.	7½	15
Diameter rolls approx. ins.	6½	6½
Distance between shaft centers ins.	6	6
Diameter pulleys ins.	20x5	20x5
Speed of Pulleys r.p.m.	200	200
Ratio of gearing	7:1	7:1
Horse power required h.p.	3 to 5	3 to 5
Speed of motor r.p.m.	1200	1200
Shipped regularly on skids approx lbs.	1750	1900

NOTE:—Furnished with tight and loose pulleys regularly. Friction clutch and direct motor attachments are extra. Furnished regularly without rolls. Rolls are made to special order. Size of motor when required direct motor drive is from 3 to 5 h. p. depending upon the kind of work to be done.

For meeting exacting requirements for an extra heavy beading machine, these new patterns are offered. The illustration serves to show that these patterns are substantially constructed and no valuable improvements have been overlooked for making them efficient in every way for the work they are specially designed for.

When fitted with friction clutch attachment, this attachment is controlled at the operator's convenience by means of a hand lever. The machine operates freely and easily on work up to the rated capacity. Bearings are bronze bushed.

The upper shaft has a parallel adjustment of 2 inches and is obtained by means of a hand wheel, worm and worm gears.

ELBOW SEAM CLOSING MACHINES

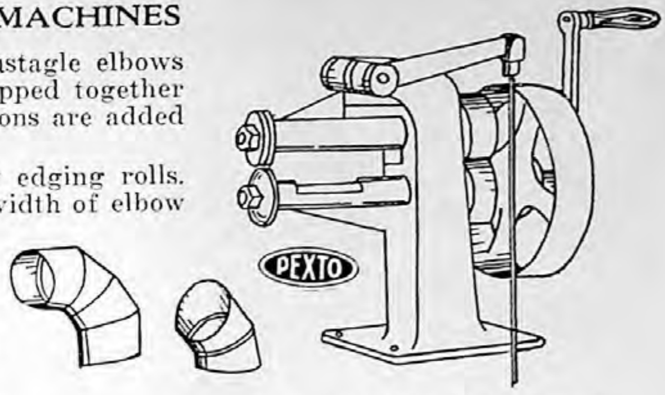
Elbow seam closers are used for assembling tight or adjustagle elbows after the elbow sections are edged. Two sections are snapped together and closed on seam closer after which the additional sections are added and closed.

Rolls for seam closers are made to match style of elbow edging rolls. Separate seam closing rolls are required for each style or width of elbow edge. Separate rolls are recommended for light tin and heavy gauge adjustable elbows.

The Number MD665 Machine is regularly furnished with geared head motor for roll speed of 120 r. p. m. But can be supplied motor driven for slower or faster speeds as may be desired.

ONE PAIR ROLLS REQUIRED FOR 3½ TO 6 INCH ELBOWS.

EXTRA PAIR ROLLS REQUIRED FOR 3" ELBOWS.



No. 665 With Tight Pulley (Capacity—26 gauge soft steel)

FOR TIGHT OR ADJUSTABLE ELBOWS 3" TO 6" IN DIAMETER

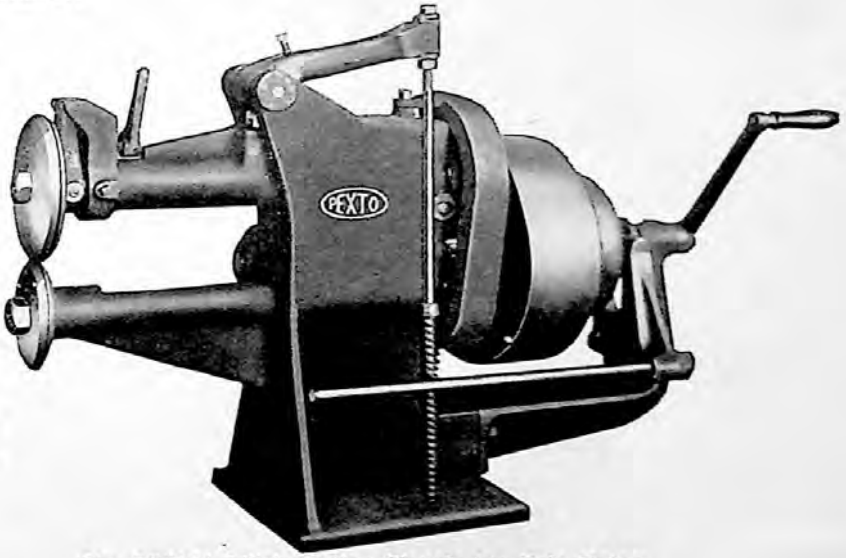
Number	Hand H665	Tight Pulley T665	Direct Motor MD665
Capacity—soft steel and lighter .... gauge	24	24	24
Diameter lower roll .... ins.	3 ⅜	3 ⅜	3 ⅜
Center distance between arbors .... ins.	2 ¾	2 ¾	2 ¾
Depth of throat .... ins.	7	7	7
Size of pulley .... ins.	....	10x2 ½	....
Speed of pulley .... r.p.m.	....	120	....
Speed of rolls .... r.p.m.	....	120	120
Motor requirements—geared head motor	....	....	⅓ h. p., 120 r. p. m.
Shipping weight boxed .... lbs.	100	115	225

NOTE:—Floor pedestal can be furnished at extra charge.

All Seam Closing Machines are regularly furnished with foot treadle attachment for depressing rolls for covenient handling of work.

ONE PAIR ROLLS ONLY REQUIRED FOR 7" TO 12" ELBOWS

No. 661½ Series Seam Closing Machines when furnished for tight elbows will accommodate split upper rolls. By means of lever seaming rolls can be spread open or closed for better suiting different thicknesses of steel, making seam absolutely tight.



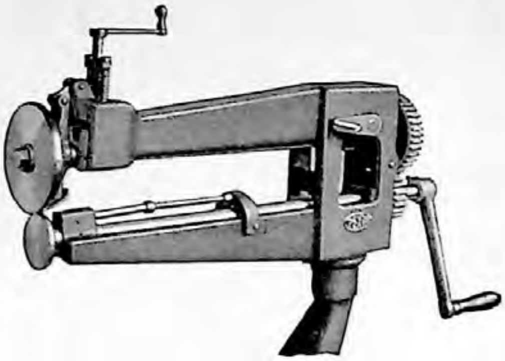
No. 0661½ With Pulley Clutch for Belt Drive

FOR TIGHT OR ADJUSTABLE ELBOWS 7" TO 12" IN DIAMETER

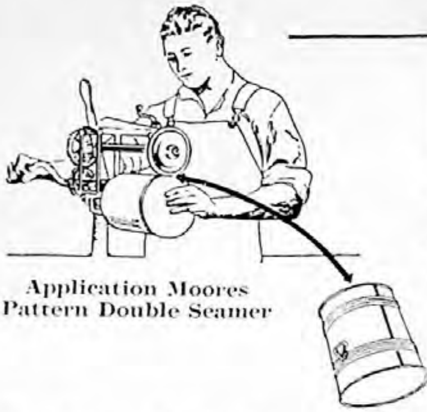
Number	Hand H661½	T & L Pulleys TL661½	Direct Motor Drive MD661½
Capacity—soft steel and lighter .... gauge	24	24	24
Diameter lower roll .... ins.	6 ⅜	6 ⅜	6 ⅜
Center distance between arbors .... ins.	5 ½	5 ½	5 ½
Depth of throat .... ins.	10	10	10
Size of pulleys .... ins.	....	12x3	....
Ratio of gearing	....	2 ½ :1	....
Speed of pulleys .... r.p.m.	....	250	....
Speed of rolls .... r.p.m.	....	100	100
Motor requirements—gear head motor			½ h. p., 100 r. p. m.
Shipping weight crated without pedestal .... lbs.	225	270	450

NOTE:—Floor pedestal can be furnished at extra charge.

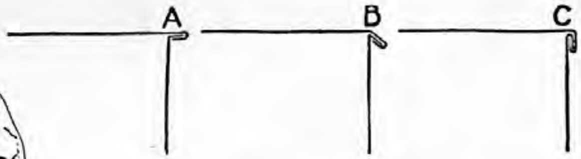
DOUBLE SEAMING MACHINES



No. 644
MOORES DOUBLE SEAMER
(Capacity—No. 26 gauge soft steel)



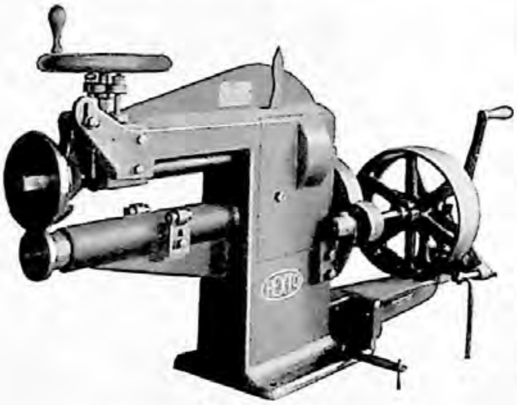
Application Moores Pattern Double Seamer



"A"—As closed down preparatory to double seaming

"B"—First operation double seaming

"C"—Second operation completing the seam



No. 641½
MOORES DOUBLE SEAMER
(Capacity—No. 24 gauge soft steel)

The Moores Pattern Double Seaming machines are adapted for general use. With these machines extra discs are not required and therefore preferred for double seaming cans or drums of varied diameters.

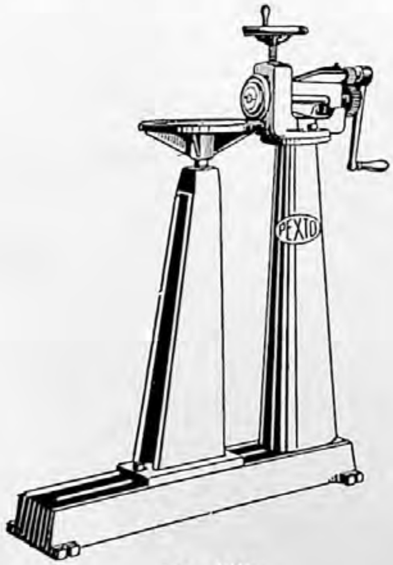
Frames are one solid and rigid casting. Arbors are heavy and gears machine cut. The small wheel behind upper roll intended to hold seam in position during first pass and prevent springing open, top roll is then shifted to right thru hand lever on right, rolls depressed tightly completing seam in second pass.

No. 644 will take work 3½ in. dia. up to 6 in. deep, 4 in. dia. up to 12 in. deep.

	Hand			
Number	**644**	**640**	**641**	**642**
Capacity—soft steel ....gauge	26	22	24	20
Will receive work in depth........ins.	15½	16½	26	16
Size lower seaming face ....ins.	2¾	3½	6	6
Smallest diameter work that can be double seamed full depth of throat ....ins.	4⅜	6½	7½	12
Shipped boxed ....approx. lbs.	100	....	....	....
Shipped crated ....approx. lbs.	....	330	400	560

	Clutch		
Number	**640½**	**641½**	**642½**
Capacity—soft steel ....gauge	22	24	20
Size pulley ....ins.	12x3	12x3	12x3
Speed pulley ....r.p.m.	75	75	75
Will receive work in depth........ins.	16½	26	16
Size lower seaming face ....ins.	3½	6	6
Smallest diameter work that can be double seamed full depth of throat ....ins.	6½	7½	12
Shipped crated ....approx. lbs.	360	430	590

NOTE: — No. 644 furnished for hand operation only with No. 975 Bench Standard. Nos. 640½, 641½, 642½ furnished with treadle friction clutch for belt drive. Can furnish on floor pedestal at extra charge.



No. 637
VERTICAL DOUBLE SEAMER
(Capacity—No. 22 gauge soft steel)

The No. 637 Vertical Double Seamer is constructed for heavy work and will double seam vessels as small as 12 in. diameter 36 in. deep and as small as 8 in. diameter 15 in. deep. The double seaming roll is beveled on outer edge, partly depressed on first pass, then fully depressed for second pass, the straight side of seaming roll finishing a tight seam.

Number	**637**
Will receive work in depth ....ins.	36
Ratio of gearing........	2:1
Shipped crated regularly ....weight approx. lbs.	550

NOTE:—Regularly furnished with one 12-inch disc. Discs of other sizes can be furnished for which an extra charge will be made. Maximum diameter disc that can be applied 26 inches.

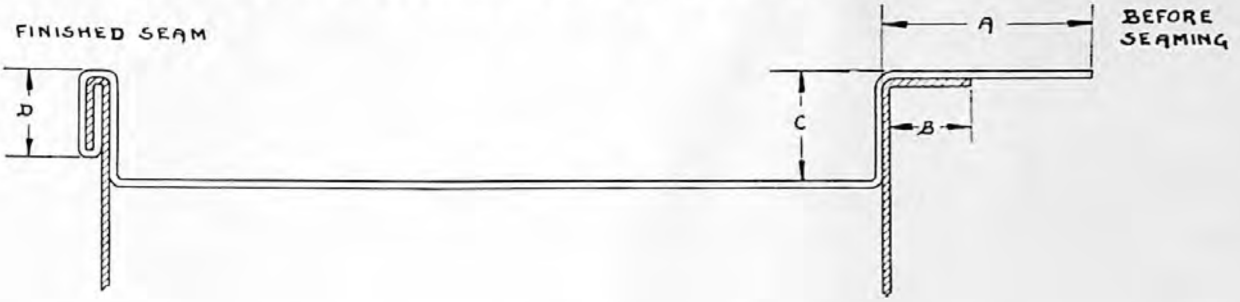
POWER PRODUCTION DOUBLE SEAMING MACHINES

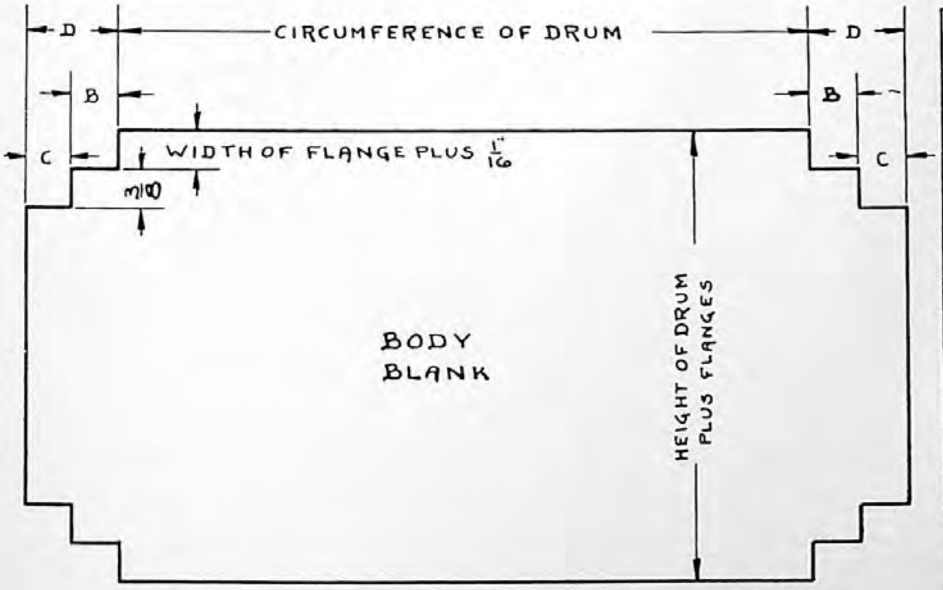
For Illustrations and Specifications see Page 100

These Double Seaming machines are now so well known that no elaborate description of their manner of working or construction is required. They can be operated by unskilled labor, and will turn out more work with better seams than can be produced by other and more expensive methods.

They are used for double seaming the ends of fruit, vegetable and other round cans, dippers, coffee pots, pans, pails and other round articles of tin or sheet metal ware. It will be understood that the tops and bottoms to be double seamed must be formed with a depression close to the seam. This operation is effected on the proper Power Press. One seaming chuck (upper) is required for each diameter of cylinder.
These machines can be modified and furnished with attachments for curling operation, flanging and other special work. Full information as to size and kind of work should accompany all inquiries.

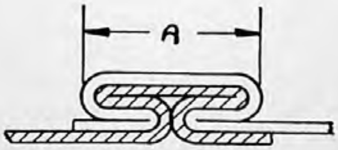
TABULATION — STEEL DRUM BODY SHEETS AND FLANGES





GAUGE OF MATERIAL	A	B	C	D
14	1 3/8	1/2	3/4	5/8
16	1 1/8	7/16	5/8	1/2
18	1	3/8	9/16	7/16
19	1	3/8	9/16	7/16
20	7/8	5/16	1/2	3/8
22	3/4	9/32	3/8	5/16
24	5/8	1/4	11/32	9/32
26	9/16	7/32	5/16	1/4
28	7/16	3/16	1/4	7/32
30	3/8	5/32	7/32	3/16
32	5/16	1/8	3/16	5/32

RECOMMENDED FLANGES FOR DOUBLE SEAMED DRUMS



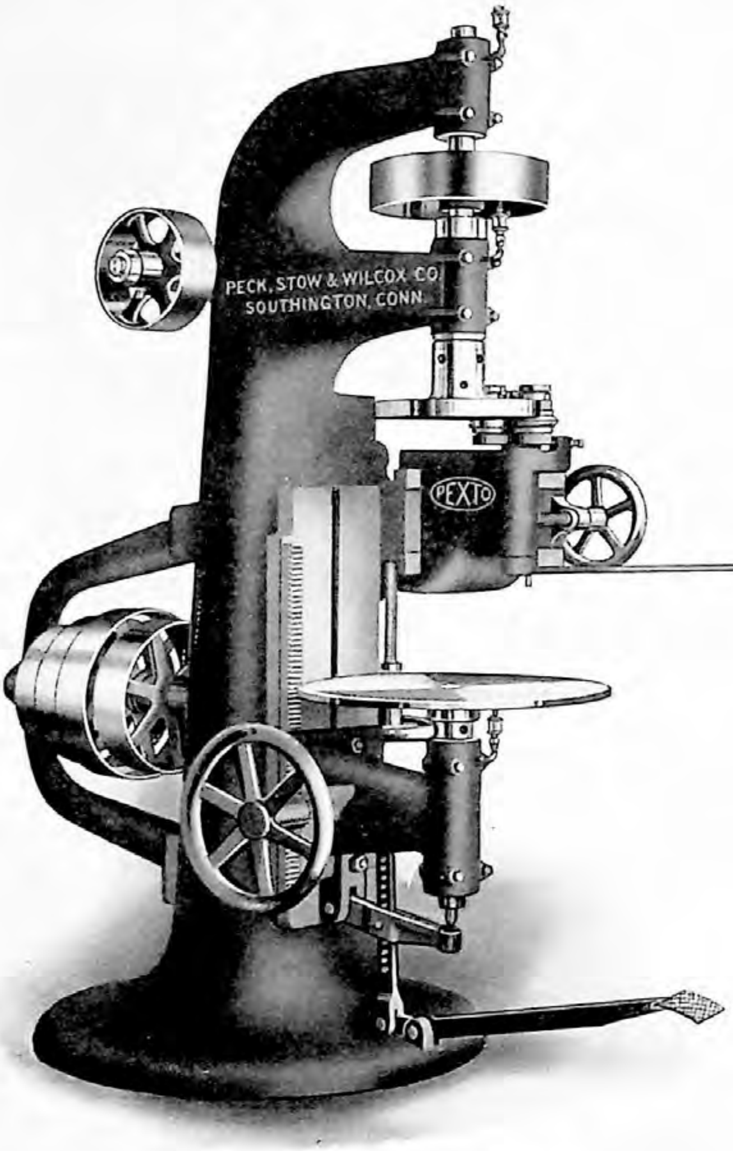
FINISHED SIDE SEAM

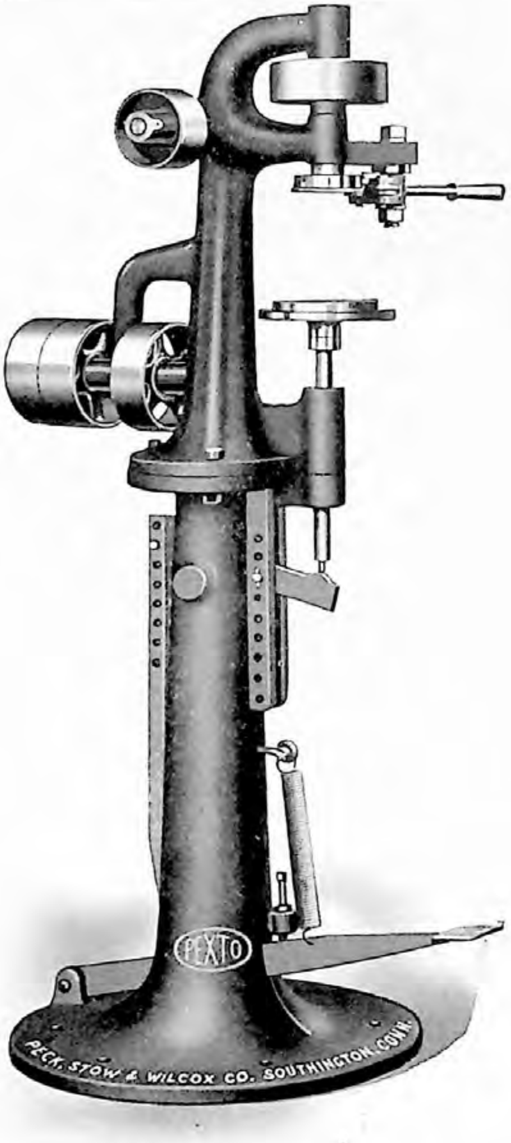
GAUGE OF MATERIAL	A	B	C	D
22 & 24 GA.	13/32	19/32	11/32	15/16
26 & 28 GA.	9/32	19/32	1/4	27/32

BLANK SIZE FOR STEEL DRUM BODIES WITH COMPOUND SIDE SEAM

POWER PRODUCTION DOUBLE SEAMING MACHINES

For Flange Tabulation see Page 99


PECK, STOW & WILCOX CO.
SOUTHINGTON, CONN.
PEXTO


PEXTO
PECK, STOW & WILCOX CO. SOUTHINGTON, CONN.

No. L5 Power Double Seamer

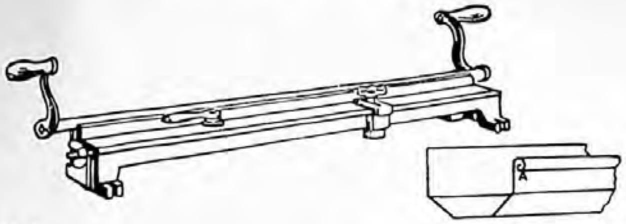
No. L1 Power Double Seamer

Number of Machine			*L1	L2	L3	L4	L5
CAPACITY	Max. ga. soft steel on min. diam.	gauge No.	24	24	22	20	20
	Max. ga. soft steel on max. diam.	gauge No.	28	28	26	24	20
Weight		approx. lbs.	300	600	1700	2700	3500
For work in diameter		ins.	2 to 10	2 to 14	4 to 20	6 to 22	8 to 26
For work in height		ins.	8½	20	21	33	35
Distance center of spindle to frame		ins.	5¼	7½	10½	12	14
Speed of spindle		r.p.m.	300 to 400	250 to 350	200 to 300	150 to 250	120 to 200
Speed of countershaft		r.p.m.	....	240	240	200	150
Size of tight and loose pulleys on countershaft		ins.	7x2	10x3	10x3¼	10x3¾	14x4½
Size of base		ins.	24	25	31	37	42
Floor space, F to B and R to L		ins.	29x20	46x39	53x44	62x52	76x67

*No. L1 is made for use either on bench or mounted on column and has tight and loose pulleys only.

Counter shaft with three step cone pulley, tight and loose pulleys, hangers and belt shifter furnished at an extra charge for Nos. L2 to L5 inclusive.

ADJUSTABLE GUTTER BEADER

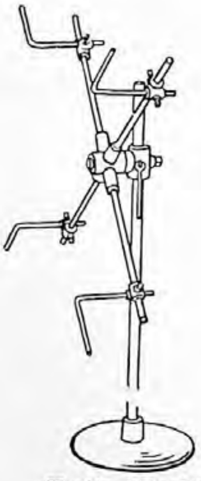


Number	700
Length for Sheets.....................width inches	30
For Rods..........................Diameter inches	$3/8$ to $7/8$
Capacity, Mild Steel, with $3/8$ inch Rod....Gauge No.	26
" " " " $1/2$ " "...." "	26
" " " " $5/8$ " "...." "	24
" " " " $3/4$ " "...." "	24
" " " " $7/8$ " "...." "	24
Shipping weight boxed ....Approx. lbs.	75

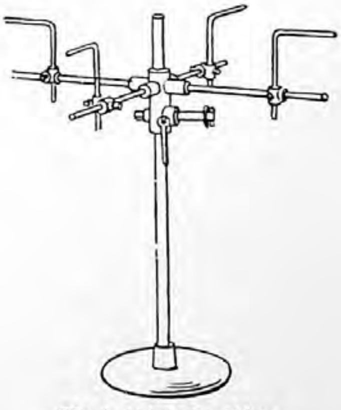
NOTE — Where specifications do not accompany orders, $1/2$ inch rod will be sent.

Gutter Beaders are intended for forming a bead on the edge of gutters, boxes, etc. This machine is so constructed that it can be easily adjusted to be used with Rods from $3/8$ to $7/8$-inch in diameter. It has a Gauge or Stop on the left-hand end, so that after adjusting the Jaws and setting the Gauge for the size of the Rod to be used, the Jaws can be easily opened to remove the work and Rod, and then closed in exactly the same position as when the bead was formed, so that the operator can form any number of beads of exactly the same size. The Jaws are adjusted by a Hand Wheel with Rack and Pinion, which adjusts both ends of the movable Jaw.

WIRE REEL



Vertical Position

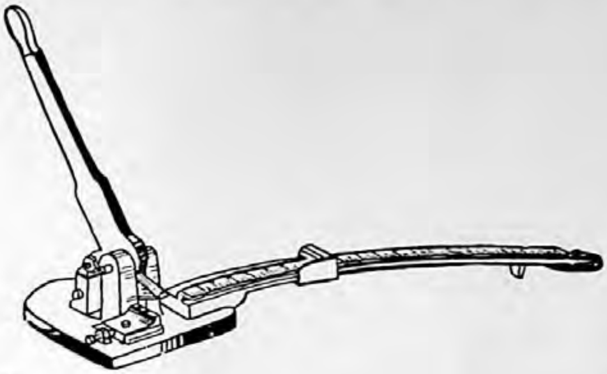


Horizontal Position

Number	758
Shipped securely packed, unboxed..weight approx. lbs.	50

The Reel, illustrated here, is made so that it can be used in a vertical or horizontal position. The Arms can be made of any length desired. As made they are of sufficient length to receive ordinary coils of wire and can be easily adjusted to receive smaller coils. Extensively in use for holding Coils of Box Strap, as well as Wire.

VAN BRAMER'S WIRE CUTTER

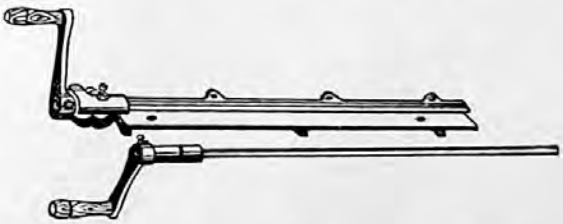


Number	490
Weight .... lbs.	50
Will cut Wire up to .... diameter inches	$1/4$
Shipped boxed regularly...........weight approx. lbs.	45

NOTE — Unless otherwise specified, shipped with Circular Attachment and Gauge.

A simple, cheap, durable and economical machine for general Wire Cutting. It takes wire from the coil and gauges and cuts it to the desired length. It cuts smoothly and easily one-quarter inch wire as well as all smaller sizes from 2 to 60 inches in length. A Circular Attachment, graduated in inches and fractions with a smoothly polished surface and fitted with Adjustable Gauge, is provided. For Straight Wire Cutting this Circular Attachment is not needed.

SINGLE AND DOUBLE LOCK EDGER



Gutter Bead

Single Lock

Double Lock

	With Edging and Gutter Rod	With Edging Rod less Gutter Rod
Number	715	716
Length .... inches	30	30
Diameter Gutter Rod..........inches	$1/2$	
Shipped packed as ordered weight ....approx. lbs.	34	29

These machines are intended for turning single and double locks in the edges of roofing sheets of light tin. They will form a single or double lock and when furnished with Gutter Rod, they will do the same work as regular 30-inch Gutter Beader.

In turning edges a Rod with a slot receives the sheet and one movement of the crank turns the edges. Stops are provided for forming single or double locks, as may be desired.

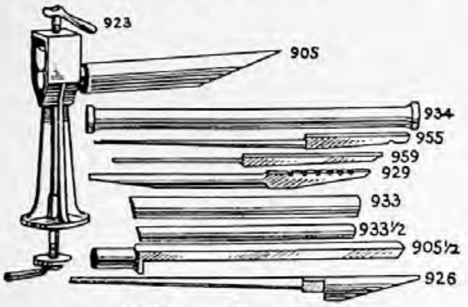
UNIVERSAL STAKE HOLDER AND STAKES No. 964

The illustration represents our Improved Stake Holder and the different Tools capable of being used with it.

This Holder enables the workman to use the Stakes shown, in any position — best suited to the work in hand without mutilating the bench. One Stake may be substituted for another with ease. It is convenient, solid, substantial, and will give satisfaction.

When ordering these Stakes other than in full sets be careful to mention "For use in Universal Stake Holder," to avoid confusion with our regular Stakes. The set is made up as follows:

Complete No. 964



Holder — Cast Iron
Stakes—Wrought Iron with Steel Faces

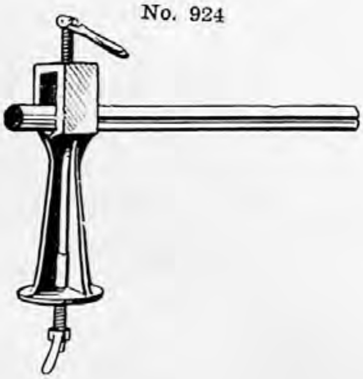
Stake Holder, only (923)	Weight 21 lbs.
Beakhorn for Stake Holder, two pieces (905) (905½)	Weight 47 lbs.
Blowhorn for Stake Holder (926)	Weight 10 lbs.
Creasing and Horn for Stake Holder (929)	Weight 8 lbs.
Double Seaming for Stake Holder (934)	Weight 23 lbs.
Conductor for Stake Holder, two pieces (933) (933½)	Weight 26 lbs.
Candle Mould for Stake Holder (955)	Weight 4½ lbs.
Needle Case for Stake Holder (959)	Weight 4 lbs.
No. 964—Full Set as above, complete, with Stake Holder	Weight 170 lbs.

EXTRA PARTS FOR No. 964

Round End for Beakhorn Stake (905)	Weight 31 lbs.
Flat End for Beakhorn Stake (905½)	Weight 16 lbs.
Large End for Conductor Stake (933)	Weight 16 lbs.
Small End for Conductor Stake (933½)	Weight 10 lbs.
Screw and Bolt for Stake Holder	
Nut for Stake Holder	

GROOVING STAKE AND HOLDER

No. 924



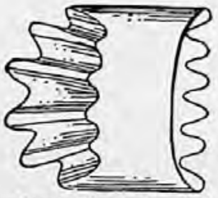
Number		924
Length Stake	inches	35
Length Grooves	inches	31½
Sizes Grooves	inches	1/8, 1/4, 3/8, 7/16
Shipped boxed regularly	weight lbs.	65

NOTE — Special Sized Grooves can be milled in the Bar at a minimum extra cost.

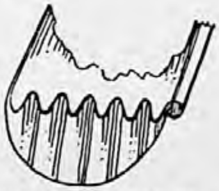
This Stake is especially adapted for rapid execution on work usually done by Hand Groover. The locks to be closed and grooved are laid in one of the grooves milled in the bar and the work is finished with a Mallet locating the groove on the inside of the work leaving the outer seam smooth and clean. Stake can be easily turned so that any of the four grooves can be used.

EAVE TROUGH END CLOSING FORMS

Cast Iron



Eave Trough End Closing Form



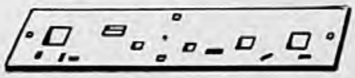
End of Eave Trough as Closed with Form

Sizes	3½	4	4½	5	6
Weight .... lbs.	3	3½	4	5⅛	7

With the use of these Eave Trough End Closing Forms the ends of eave trough can be closed much neater and quicker than with any other method. The Form is placed in gutter and the iron is worked into grooves with a Hammer, producing a corrugated, closed end in any eave trough on which the Forms are used, as shown in the illustration.

A paper pattern showing how to cut end of Trough and complete working instructions are packed with each Form.

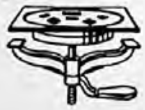
BENCH PLATES OR STAKE HOLDERS



Cast Iron

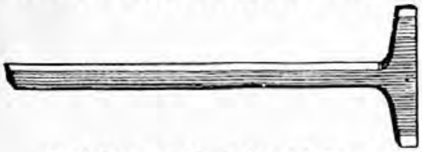
Number		982	981	980
Length	inches	30	37½	48
Width	inches	8	8	12
Packed as ordered	weight lbs.	31	46	85

REVOLVING BENCH PLATE OR STAKE HOLDER



Number		983
Size	inches	8¾x8¾
Packed as ordered	weight lbs.	20

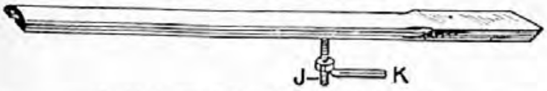
SOLID MANDREL STAKES



Cast Iron with Polished Faces

Number		960½	961	962
Length to Standard	inches	40	34½	30
Diameter	inches	3	2¾	2¼
Packed as ordered	weight lbs.	86	56	43

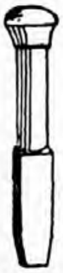
HOLLOW MANDREL STAKES



Cast Iron with Polished Faces

Number		910	911
Entire Length	inches	40	60
Length Flat Part	inches	9	12
Width Flat Part	inches	6	7
Length Oval Part	inches	31	48
Size Oval Part Radius of Circle	inches	2	2½
Packed one in a box, regularly	weight lbs.	60	110

Hollow Mandrel Stakes are cast iron and are made as good as it is possible to make a Stake in cast iron, but we cannot guarantee them against breakage through misuse, and will be liable for breakage that show flaws in material only. Working surfaces are machined finish with true radius and straight edges.



No. 965

No. 965

Cast iron, polished face.

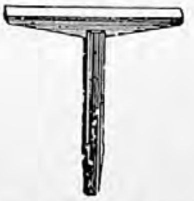
No. 947

Has flat face. Two straight edges — one convex edge, one concave edge. Has steel hardened face. Size face 5x5½ ins. Thickness of head 15/16 ins.

No. 947

		Hand Dolly	Round Head
Number		947	965
Entire Length	inches	....	12½
Diameter Head	inches	....	3
Size Face	inches	5x5½	....
Thickness of Head	inches	15/16	....
Packed as ordered	weight lbs.	8½	9½

HATCHET STAKES



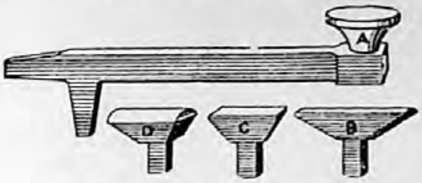
High Carbon Steel with Faces Hardened and Tempered

Number		941	943	944
Length Blade	inches	16	13	11
Width Blade at Center	inches	2½	2⅛	2⅛
Width Blade at Ends	inches	1⅝	1¼	1⅜
Packed as ordered	Weight, lbs.	14	9½	6½

DOUBLE SEAMING STAKE

No. 949

WITH FOUR HEADS

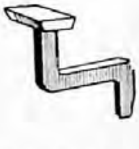


Cast Iron with Polished Faces

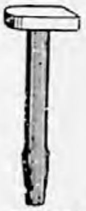
		Ext. Heads			
Number	949	A	B	C	D
Lgth. from Top of Head to Standard......inches		4¼	2½	2½	2¾
Size of Sq. and Oval Heads. ins.			8½x2⅝x3¼	5½x4½	5¾x4¼x3¾
Dia. Rd. Hd. ins.		6			
Shipped boxed regularly. wt. lbs.	110				

STAKES

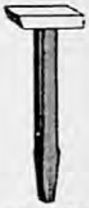
High Carbon Steel with Faces Hardened and Tempered



Bevel Edge Square Stake Nos. 931-932



Coppersmiths' Square Stake No. 935



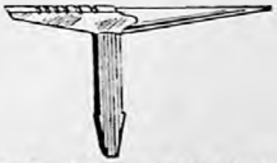
Square Stake Nos. 936-938

	Lge. B. E.	Sm. B. E.	Cop. Sq.	Com.Sq.	Lge..Sq.
Number	931	932	935	936	938
Size Face .....inches	3x5	2½x4½	2¾x4½	2¾x4½	3x5
Weight ....lbs.	16	14	11	11	14

Packed as ordered.

CREASING STAKE

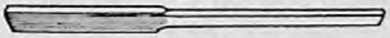
No. 927, With Horn



High Carbon Steel with Faces Hardened and Tempered

Number		927
Size Grooves for Wire	No.	2, 3, 6, 7, 8, 9
Round End, Length	inches	12
Flat End, Length	inches	6¾
Diameter Round End at Largest Point	inches	1½
Diameter Round End at Smallest Point	inches	7/16
Packed as ordered	Weight, lbs.	12

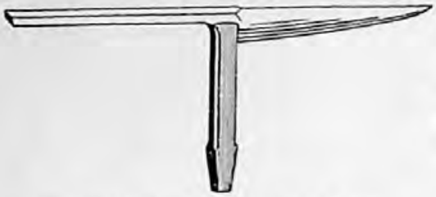
PLAIN MANDREL



Cast Iron with Polished Faces

Number		968
Width of Flat Part	inches	2¾
Width Oval Part Tapers	inches	2[illegible] to 2¾
Length Over All	inches	43¾
Length Flat Part	inches	17¾
Length Oval Part	inches	26
Shipping Weight	approx. lbs.	47

BEAKHORN STAKES

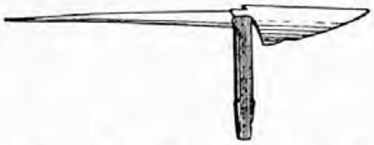


Wrought Iron with Steel Faces

Number	901	904
Round End, Length ....inches	16½	14
Flat End, Length ....inches	21½	19
Width of Flat End, Tapers ....inches	2½x1⅞	2x1½
Diameter Round End at Smallest Point....inches	⅞	⅝
Diameter Round End at Largest Point ....inches	2½	2
Packed as ordered ....weight lbs.	46	27

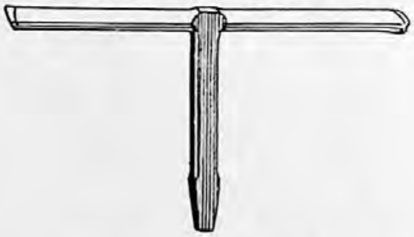
BLOW HORN STAKE

Number	925
Large End, Length ....inches	9
Small End, Length ....inches	18
Diameter Small End at Largest Point ....inches	1½
Diameter Small End at Smallest Point ....inches	⅜
Diameter Large End at Largest Point ....inches	4¾
Diameter Large End at Smallest Point ....inches	½
Packed as ordered ....weight lbs.	14



Wrought Iron with Steel Faces

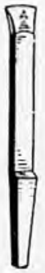
DOUBLE SEAMING STAKE



Wrought Iron with Steel Faces

Number	921
Large End, Length ....inches	17
Small End, Length .....inches	12
Size Each End ....inches	3x1¾
Packed as ordered..weight lbs.	37

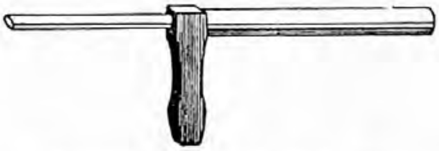
BOTTOM STAKE



Wrought Iron with Steel Faces

Number	953
Length Over All........inches	13½
Width Across Top......inches	1⅛
Packed as ordered..weight lbs.	2

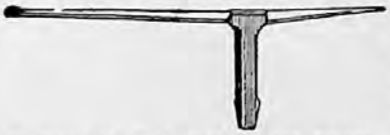
CONDUCTOR STAKE



Polished Steel Ends, Cast Stem

Number	971
Length Large End......inches	15
Length Small End......inches	11½
Diam. Large End.approx. inches	2¼
Diam. Small End.approx. inches	1⅜
Packed as ordered..weight lbs.	28

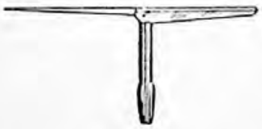
CANDLE MOULD STAKE



Wrought Iron with Steel Faces

Number	956
Large End, Length ....inches	18½
Small End, Length ....inches	9½
Diameter Small End at Largest Point..inches	1¼
Diameter Small End at Smallest Point.inches	½
Diameter Large End at Largest Point.inches	⅞
Diameter Large End at Smallest Point..inches	½
Packed as ordered ....weight lbs.	7½

NEEDLE CASE STAKE

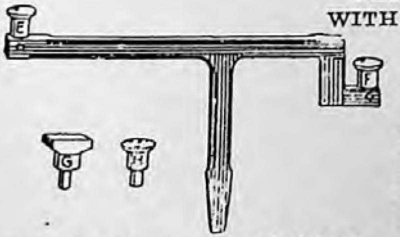


Wrought Iron with Steel Faces

Number	957
Round End, Length.....inches	10½
Flat End, Length.......inches	8
Width Flat End........inches	1
Diameter Round End at Smallest Point........inches	⅜
Diameter Round End at Largest Point ....inches	⅝
Packed as ordered..weight lbs.	4

TEA KETTLE STAKE

WITH FOUR STEEL HEADS



Wrought Iron — Steel Heads

Number	958	Extra Heads E	Extra Heads F	Extra Heads G	Extra Heads H
Height Over All....inches	16	..	..	..	..
Length Over All....inches	32	..	..	..	..
Size of Sq. Heads..inches		..	..	2¾x1¾	..
Diam. Round Heads.inches		2 13/16	2⅝	..	2 9/16
Shipped boxed regularly weight..............lbs.	75				

BURRITT'S ROOFING DOUBLE SEAMERS

Number	Common Ga. 742	Wide Ga. 742½	Iron Ga. 0742
Shipped packed as ordered. Weight per Set of Two Pairs	38	38	42

NOTE — Nos. 742 and 742½ are fitted for I. C. Tin. No. 0742 is fitted for Iron Roofing not heavier than 26 gauge for single or double seam. Common gauge Seamers No. 742 follow 1 and 1¼- inch Tongs, finishing a lock ¾-inch high. Wide gauge Seamers No. 742½ follow 1¼ and 1½-inch Tongs, finishing a lock 1 inch high. Iron Roofing Double Seamers No. 0742 are made 1-inch and 1½-inch and follow 1½ and 1¾-inch Tongs, finishing a double seam 1 inch high. Specify by number. Where Seamers are ordered in half sets, be sure to specify whether the first or second pair of Seamers are desired.

DOUBLE SEAMERS FOR TIN ROOFING

Nos. 742 and 742½

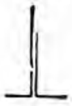
These Roofing Double Seamers for Standing Lock will do the work more evenly than by any other process and leave the formed lock of uniform height. They will work well over uneven roof boarding and will double seam hips and ridges with perfect ease.

The first pair of Common-gauge Seamers finish 1-inch seam single lock, and is numbered 7 on the Outside Bar and 8 on the Center Bar.

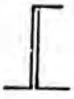
The second pair of Common-gauge Seamers finishes ¾-inch seam, double lock, and is numbered 9 on the Center Bar and 10 on the Outside Bar.

The first pair of Wide-gauge Seamers, finishes seam 1¼-inch, single lock, and is numbered 5 on the Outside Bar and 3 on the Center Bar.

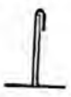
The second pair Wide-gauge Seamers finishes seam 1 inch, double lock, and is numbered 4 on the Center Bar and 6 on the Outside Bar.



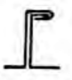
Ready for Double Seam Roofing Edges Turned



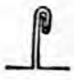
First Operations in Double Seaming



Second Operation



Third Operation



Completing the Seam

WOOD ROOFING FOLDERS

Common Roofing Folder
Nos. 13C, 23C

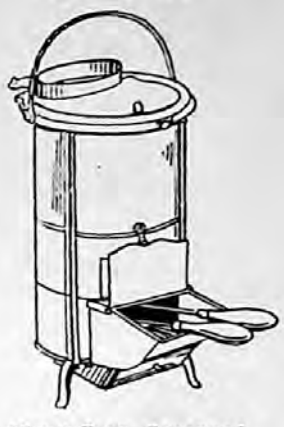
Improved Roofing Folder
Nos. 113 Imp., 123 Imp.

Number	13C	23C	113 Imp.	123 Imp.
Size for Sheets width ....inches	20	28	20	30
Will form locks size ....inches	5/16	5/16	3/16 to 3/8	3/16 to 3/8
Packed as ordered ....weight lbs.	9	11	10	17

NOTE — C after number signifies Common Type and fitted for one size lock only. Imp. after number signifies Improved Pattern with Adjustable Gauge.

The same care as is exercised in constructing other high-priced Folding Machines in the Pexto line is given to Wood Roofing Folders. They are different from the average Wood Roofing Folder on the market which is made in cheap construction to fit a common purpose. Pexto Wood Roofing Folders, while made for the same purpose are constructed of well-seasoned wood fitted with blades of high-grade special steel, accurately machined and finely finished. Hinges and Handles used are not of the cheap grade. They are constructed throughout in a workmanshiplike manner.

FIRE POT

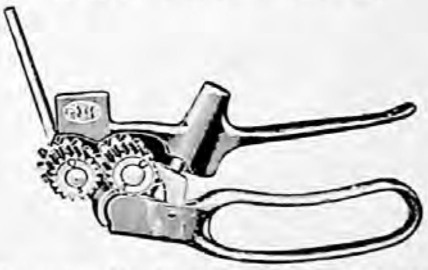


Sheet Iron, Japanned

Number	782
Packed as ordered .. weight lbs.	15

Fire Pot, No. 782, is so constructed that the ashes fall into a pan beneath the coal and the fire is kept clear and the draft is good. It is light and may be easily carried from place to place with convenience.

HAND PIPE CRIMPER



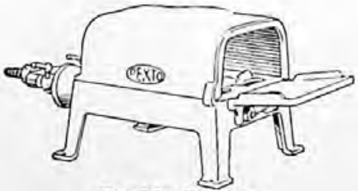
Capacity—No. 26 Gauge Iron and Lighter.

To crimp a piece of pipe with machine-like effect and precision slip the end of the pipe between the crimping rolls. Close the rolls by pushing down lever. With an up-and-down movement of the handle, by means of a ratchet, the rolls rotate, making a perfect crimp. Depth of crimp is regulated by adjustment of the set screw. Steel rolls and gears.

Number	788
Length over all, inches	8
Weight, lbs. each	1⅞

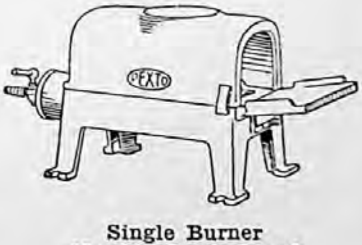
Packed one in a box.

GAS FURNACES



Double Burner
No. 332 Plain.
No. 333 Brick Lined.

Lead Pots to Fit Furnace
No. 322
Extra.



Single Burner
No. 331 Brick Lined.

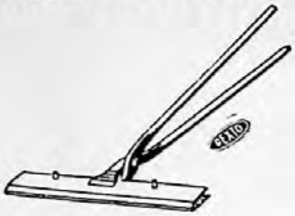
Number	331	332	333
Packed One in a Carton .... weight lbs.	10	14	16

NOTE—Plain Furnaces have Cast Iron Tops with opening to receive a Lead Pot. Furnaces Brick Lined have Sheet Iron Tops.

These Furnaces will burn natural or artificial gas, and will prove serviceable for general use in heating soldering coppers. No air blowers being required, they will prove very desirable for heating coppers in every shop. By regulating the aperture through which the air passes, so that the flame has a blue appearance, the very hottest flame produced by gas can be secured. Always ready for use and with the proper flow of gas will produce a blue hot flame. They are practical, well made and inexpensive.

ROOFING TOOLS

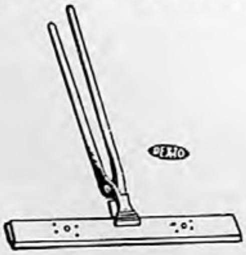
COMMON ROOFING TONGS



Number	770¾	771	771¼
Will turn one size lock ....ins.	¾	1	1¼
Length handles from bolt ....ins.	23½	23½	23½
Width blades ....ins.	1¾	1¾	1¾
Length blades ....ins.	18½	18½	18½
Packed as ordered .... weight, lbs.	9	9	9

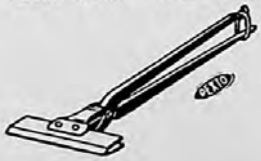
Number	771½	771¾
Will turn one size lock ....ins.	1½	1¾
Length handles from bolt ....ins.	23½	23½
Width blades ....ins.	2¼	2¼
Length blades ....ins.	18½	18½
Packed as ordered .... weight, lbs.	10	10

ADJUSTABLE PIN ROOFING TONGS



Number	773
Will turn six different widths of locks ....ins.	½, ¾, 1, 1¼, 1½, 1¾
Length handles from bolt ....ins.	23½
Width blades ....ins.	2¼
Length blades ....ins.	18½
Packed as ordered .... weight, lbs.	10

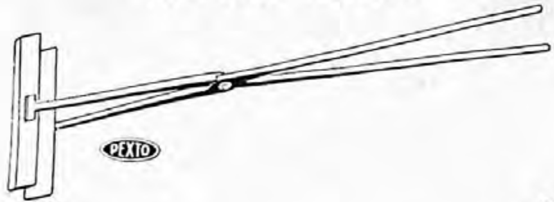
CLAMP TONGS



Number	765
Depth jaws ....ins.	3
Length handles ....ins.	14
Width blades ....ins.	1½
Length blades ....ins.	6
Packed as ordered ....weight, lbs.	3½

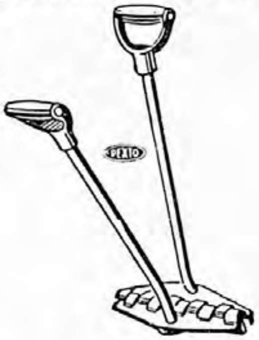
NOTE:—Clamp Tongs are used for drawing together the two layers of tin for cleating.

GUTTER TONGS



Number	777
Depth jaws ....ins.	14
Length handles ....ins.	24½
Width blades ....ins.	1¾
Length blades ....ins.	12½
Packed as ordered ....weight, lbs.	10

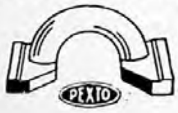
SQUEEZING TONGS



Number	766
Length squeezing jaws ....ins.	11½
Depth squeezing jaws ....ins.	⅞
Length handles ....ins.	24
Packed as ordered ....weight, lbs.	17

NOTE:—Squeezing Tongs are used on roll and cap roofing and they are also generally used on pressed standing seam roofing.

HAND ROOFING DOUBLE SEAMERS



Number	743	Common Gauge 744
Sizes ....ins.	½x¾	¾x1
Weight per set ....lbs.	14	16
Match up with roofing tongs...ins.	¾x1	1x1¼
Packed as ordered		

Number	Wide Gauge 745	Iron Gauge 746
Sizes ....ins.	1x1¼	1¼x1½
Weight per set ....lbs.	19	22
Match up with roofing tongs...ins.	1¼x1½	1½x1¾
Packed as ordered		

Shipped in sets of two seamers unless otherwise specified.

BALL PEIN HAMMERS

Drop Forged Steel

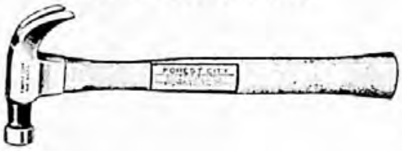
Polished Pein and Face. Black Body.

Number and Size	4B	3B	2B
Weight, ozs.	32	28	24
Length handle, inches	16	16	15½
Weight per doz., lbs.	28	25	23
Number and Size	1B	0B	00B
Weight, ozs.	20	16	12
Length handle, inches	15½	14	14
Weight per doz., lbs.	21	18	13
Number and Size	000B	0000B	00000B
Weight, ozs.	8	6	4
Length handle, inches	13	11⅝	11
Weight per doz., lbs.	10	7½	5½

No. 1 and larger in boxes of one-third dozen.

No. 0 and smaller in boxes of one-half dozen.

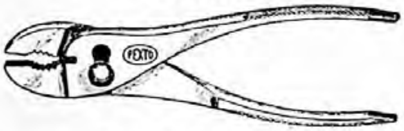
NAIL HAMMERS



Drop Forged Steel
Bell Face
Polished, Black Enamel on Neck and under Claw

Nos.	010	011	011½
Weight without handle, ozs.	28	20	16
Length handle, inches ..	14	13½	13

SLIP JOINT COMBINATION PLIER



Drop Forged Steel
Nickel Plated

No. 5

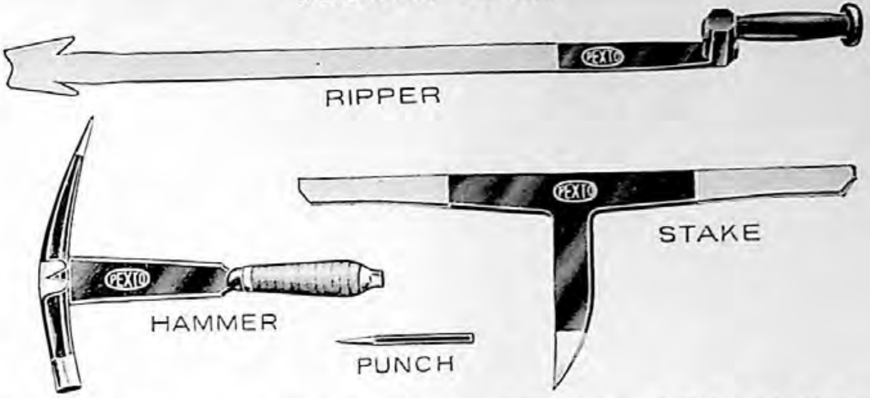
The Slip Joint type of design, permitting a wider opening of the burner jaws, is an aid to all-around use. Screw driver end.

Inches	6	8	10
Weight, lbs. per doz.	6	8	10

HICKORY MALLET

Number	3
Diameter of face ....ins.	2⅜
Length of head	5¼
Length of handle ....ins.	11
Weight, each ....lb.	1

SLATERS' TOOLS



These tools used extensively in the Laying and Repairing of Slate and other kinds of roofing are drop forged from the Highest Grade materials. The Blade of the Ripper is drawn down very thin from tool steel, having a Forged Handle. Hammers are made of Solid Forgings from crucible steel, with properly tempered head, point and cutting edges. A Leather Handle that will not break or wear out easily, smoothly finished to fit the hand snugly is used on our Slater's Hammer.

RIPPERS

No. 986 —Regular, 24½ inches, weight, 2 14-16 lbs.

HAMMERS

No. 987 —Regular, weight, 1⅜ lbs., length, 11½ inches, head, 9⅞ inches.

STAKES

No. 988 —Regular, 18 inches, weight, 2 2-16 lbs.

No. 989 PUNCH

PLIERS

Drop Forged Steel

No. 90

BUTTON'S PLIER AND WIRE CUTTER

Blued Handles

Flats of Head and End of Nose Polished

This Plier is made with positive stop for wire cutting and is of general all-around usefulness.

Inches	6	8	10	12
Wgt., lbs. per doz.	6	9	14	25

In boxes of one each.

In cartons of six each.

Flat Nose, No. 200   Round Nose, No. 250

Knurled Handles. Full Polished

Inches	5	6	8
Wgt., lbs. per doz.	2¾	3¾	9

In boxes of one each.
In cartons of six each.

SOLID AND PRICK PUNCHES

SOLID PUNCHES

PRICK PUNCH No. 38

Octagon Forged Steel

				SOLID PUNCHES			
Number	38	00	0	1	2	3	4
Size Face .... dia. inches		.355	.305	.280	.250	.225	.213
Length .... inches	5½	5	5	4¾	4¾	4½	4½
For Rivets .... lbs.			16	14	12	9, 10	7, 8

SOLID PUNCHES

Number	5	6	7	8	9	10
Size Face .... dia. inches	.188	.168	.145	.128	.114	.093
Length .... inches	4½	4½	4½	4½	4½	4½
For Rivets .... lbs.	4, 5, 6	3, 3½	2, 2½	1¼, 1½, 1¾	¾, ⅞, 1	½, ⅝

Packed one dozen in a carton.

SCRATCH AWLS

The Steel Blade or Shank on these Scratch Awls is ¼ inch diameter and goes thru the wood handle reinforcing its top. They have needle point, are full polished and have black finish wood handles.

No. 21
Blade 2¾ inches. Length over all 5⅞ ins. Weight per dozen 1½ lbs.

No. 22
Blade 3½ ins. Length over all 6½ ins. Weight per dozen 2¼ lbs.

No. 23
Blade 4¼ ins. Length over all 7½ ins. Weight per dozen 3½ lbs.

In boxes of one-half dozen each.

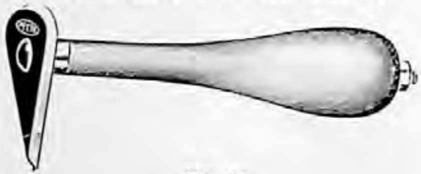
SOCKET SCRATCH AWL
Forged Steel
Length of Blade 5 inches

No. 1—Polished, Plain Handle; weight per dozen, 1¾ lbs.
No. 15—Gun Metal Finish, Cherry Handle; weight per dozen, 1¾ lbs.

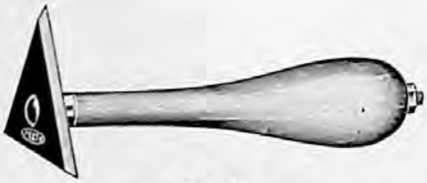
In boxes of one dozen each.

RING SCRATCH AWL SOLID STEEL
No. 01—Length over all 8 inches; weight per dozen 1¾ lbs.
In boxes of one dozen each.

PLUMBERS' SCRAPERS



No. 11



No. 12

Blades, Forged Steel, Tempered. Length of Handle, 5 inches.

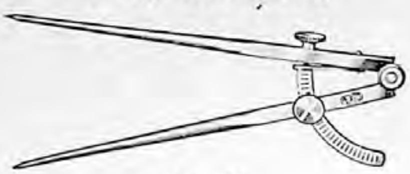
No. 11—Oval; weight per dozen, 1¼ lbs.
No. 12—Triangular; weight per doz., 1¾ lbs.

Packed one-half dozen in a box.

SOLDERING COPPER HANDLES

WIRED
No. 31—Soldering Copper Handles. Weight per dozen, 1¼ lbs.
Packed in bulk as ordered.

WING DIVIDERS



No. 165

Forged Steel. Nickel Plated

Wings are knurled to hold special point on thumb screw.

Have Brass Joints and Hardened Points.

Inches	6	7	8
Weight, lbs. per dozen	3½	4¼	4½
Inches	10	12	
Weight, lbs. per dozen	8	10	

MELTING LADLES

Cast One Piece Bowl, Double Lipped, Wrought Iron Handle, Riveted to Bowl.

Nos.	1	2	3	4
Diam. of Bowl, in.	2½	3	3½	4
Lgth. of Hdl., ins.	10½	11	11	11
Wgt., lbs. per doz.	8	9½	11	13
Nos.	5	6	7	
Diam. of Bowl, in.	4½	5	6	
Lgth. of Hdl., lbs.	13	13	14½	
Wgt., lbs. per doz.	20	24	30	

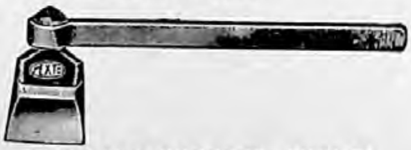
SOLDERING COPPERS

Drawn Copper Bolts. Forged.
With Square Points for Common use.

Nos.	½	¾	1	1½	2
Wgt., lbs. per pr.	½	¾	1	1½	2
Nos.	2½	3	4	5	6
Wgt., lbs. per pr.	2½	3	4	5	6
Nos.	7	8	10	12	14
Wgt., lbs. per pr.	7	8	10	12	14

Packed as ordered.

NOTE: Prices on Coppers are subject to changing market.



HATCHET COPPERS, SWIVEL HANDLES

For Swivel Handle Hatchet Coppers add 10 cents per pound to price of Regular Square Point Soldering Coppers.

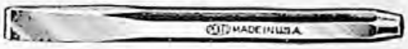
No. 25S. Sizes 2, 3, 4, 5, and 6 lbs.

BOTTOM COPPERS

Bottom Coppers can be furnished as follows at price of the regular Square Soldering Coppers.

Sizes 3, 4, 5, 6, 8, 10 and 12 pounds.

COLD CHISELS



No. 100

Forged Tool Steel, carefully tempered. Polished Blade and Head.

Inches, cut	¼	5/16	⅜	7/16	½
Inches, diameter.	¼	5/16	⅜	7/16	½
Length, inches	5¼	5¼	5¾	6	6
Wgt., lbs. per doz.	¾	1½	2	3	3½
Inches, cut	⅝	¾	⅞	1	1⅛
Inches, diameter.	⅝	¾	⅞	1	1⅛
Length, inches	6⅝	7½	7¾	8	8½
Wgt., lbs. per doz.	7	10	18	20	25

EXTRA LONG

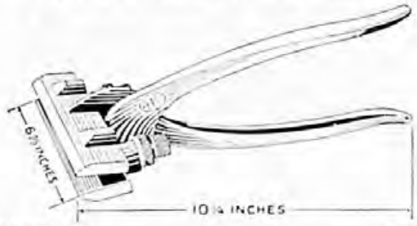
No. 112—12 inches long.
Sizes, inches ½ ⅝

No. 115—15 inches long.
Sizes, inches ¾ ⅞ 1

¼ to 7/16 inches, inclusive, one dozen in a box.

Other sizes one-half dozen.

JUMBO HANDY SEAMER

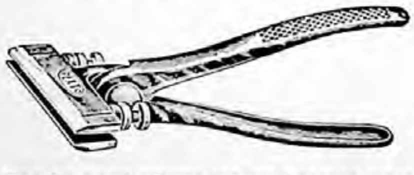


Number	795
Length of blade ins.	6⅞
Width of blade ins.	1 3/16
Size over all ins.	10¼
Adjustable for seams of different widths up to ins.	1
Weight, each lbs.	3

Packed as ordered.

The name Jumbo is derived from the difference in the size of this Handy Seamer over the one shown below. It is larger and heavier and patterned in keeping with the requirements of the roofer and for such work demanding a well balanced substantial tool of this kind. A knurled adjustable screw gauge with knurled lock nuts is provided.

'HANDY' SEAMER



Can be used where larger Seamer would not be practical. As it is light and measures but 7¼ inches by 3½ inches it can be carried in tool kit or pocket.

Length of Blade, 3½ inches.
Width, ⅞ inches.

Adjustable for seams of different width, 3/16 to ⅞ inches.

No. 791—Handy Seamer Japanned; weight, 1 lbs. each.
Each wrapped in paper.
Packed as ordered.

RIVETING AND SETTING HAMMERS

Beveled
RIVETING HAMMER
Polished Head — Hickory Handle

Square Face
SETTING HAMMER
Polished Head — Hickory Handle

Riveting Hammers

Number	0	1	2	3	4	5
For	Heavy Work	Sheet Iron	Tin	Tin	Tin	Tin
Size Face ....inches	1¼	1⅛	1	⅞	¾	⅝
Weight each ....ounces	30	20	16	14	10	4
Length Head ....inches	5⅛	5	5¼	5¼	4 3/16	3 3/16

No. 0 packed four in a carton.
Other numbers six in a carton.

Setting Hammers

Number	1	2	3	4	5
Size Face ....inches	1 1/16	1	15/16	11/16	⅝
Weight each ....ounces	20	16	14	10	4
Length Head ....inches	5¼	5 3/16	4¾	4 11/16	4

Packed six in a carton ....

NOTE—Add "CF" after number if Chamfered Face is required.

HAND GROOVING TOOLS

Forged Steel — Polished Head

Number	0000	000	00	0	1	2	3	4	5	6	7	8
Size Groove ....inches	19/32	17/32	7/16	⅜	11/32	5/16	9/32	7/32	5/32	⅛	7/64	3/32
Weight each ....lbs.	1½	1½	1¼	1¼	1¼	1¼	1	1	¾	¾	¾	¾

Packed two in a package.

RIVET SETS

No. 46 Tinners' Special Forged Steel Rivet Sets — Full Polished

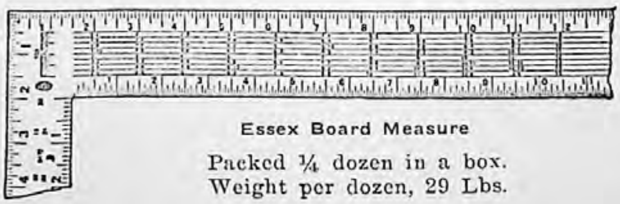
Size	00	0	1	2	3	4	5	6	7	8
Size Hole .... inches	5/16	9/32		.2130	.1910	.1660	.1495	.1405	.1285	.1100
Size Drill..Gauge No.	5/16	9/32	15/64	3	11	19	25	28	30	35
For Iron Rivets .. lbs.	14,16	10,12	7,8	6	4,5	3,3½	2,2½	1½,1¾	1,1¼	10,12 oz.
For Copper Rivets, Nos.		5	6	7	8	9	10,11	12	13,14	15
For Copper Rivets, in.		¼	7/32	3/16	5/32	9/64	⅛	7/64	3/32	3/32

Packed one-half dozen in carton. Nos. 00, 0, 1, 2, packed one-sixth dozen in carton.

GENERAL DESCRIPTION.

These sets, forged from a high quality steel, are made with a view to satisfactorily filling the requirements of hard service. They embody not only the best materials but the highest grade workmanship. Highly adapted for workers in Sheet Iron, Copper, Brass, etc.

STANDARD STEEL SQUARES



Essex Board Measure

Packed ¼ dozen in a box.
Weight per dozen, 29 Lbs.

No. 14—Size of body, 24x2 ins.; size of tongue, 16x1½ inches. The No. 14 series are graduated ⅛ and ¼ inch and have markings for Essex's board measurements.

RAISING HAMMERS

Forged Steel — Natural Finish
Polished Faces

Number	1	2
Size Faces .... inches	2⅛x1⅝	2x1½
Weight each .. ounces	80	58

Number	3	4
Size Faces .... inches	1⅝x1¼	1⅜x1⅛
Weight each .. ounces	32	28

HOLLOW PUNCHES

Forged Steel

NOTE—Hollow Punches should be used with a block of lead under the sheet of metal to be punched and only on the usual run of tin plate and light gauges of black and galvanized iron. Used with care and good judgment they will give satisfactory service. We offer them in sizes from 3/16 to 4 inches diameter.

CUTTING NIPPERS

WITH REMOVABLE JAWS

Each of the jaws has two fine cutting edges.

Jaws held in place by two screws and are easily reversible, adjustable and interchangeable.

Nos.	0	1	3
Length, inches	14	12	10
Width of Cutting Jaws, inches	2	1¾	1½
Weight per pair, lbs.	3½	2¼	1½

Nos.	4	5
Length, inches	8	6
Width of Cutting Jaws, inches	1¼	1
Weight, per pair, lbs.	1	¾

WITH JAWS FOR CUTTING MUSIC WIRE

Nos. M0 M1 M3 M4 M5

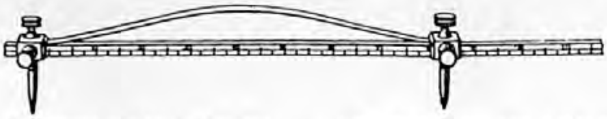
Packed one-sixth dozen in a box.

ROOFING SCRAPER

These Scrapers are forged from high grade steel, are well tempered, finely finished and in all respects are perfect tools.

Number	996
Size .... inches	3/16x⅝x10
Packed six in a carton, weight .... lbs.	2

THE "MAGIC" PATTERN RULE WITH CHART



For laying out Sheet Metal Elbow Patterns up to 14 inches in diameter and at any angle desired in a few minutes time. A great labor-saving tool.

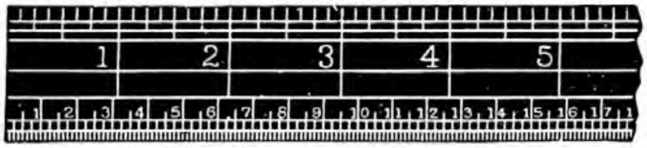
Consists of a 7/16 inch square steel bar, marked circumference inches one side, and inches and eights other side. Fitted with brass sliding trammel heads with set screws and steel points, all nicely nickel plated. For laying out elbow patterns, the left-handed slide is fastened to the end of the bar by the set screw, and the right-hand slide is set according to the diameter elbow that is wanted. A flexible steel ribbon on the top of the bar is then raised to the required height, according to the angle of elbow wanted, one glance at the chart giving such height necessary according to the elbow required.

For example, suppose an elbow is wanted say 6 inches in diameter, and at an angle corresponding with the long line C on the chart; set the right-hand slide at figure 6 on the front of rule, get with your ordinary rule the distance from bottom of diagram on the chart of the perpendicular line 6 where it meets the angle C; then raise steel ribbon to this height, fasten it with set screw, and you have it set for a pattern.

The chart is 19 x 23 inches in size, mounted on linen and very durable and contains, besides the elbow diagram, also rules for cutting all kinds of flaring, oval, cylindrical, cone-shaped vessels, etc. with the aid of the Magic. Besides all this, the Magic can be used for a straight edge, rule, circumference rule and trammel.

Put up in neat, hinged, wooden box, and is provided with three steel ribbons of different gauges, which may be used according to size of elbow wanted. Weight each, 7 lbs.

FLEXIBLE STEEL CIRCUMFERENCE RULE

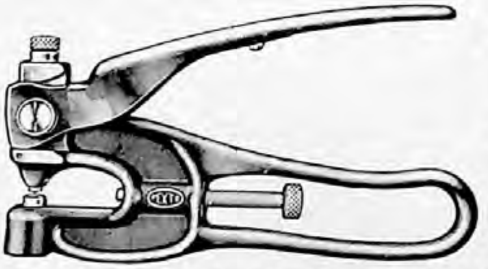


A Steel Rule that will prove invaluable for laying out work in general. The cut is an exact representative so far as shown; its entire length is 36 inches. The upper line is the Ordinary Rule graduated by eights of an inch. The lower line shows at a glance the exact circumference of any cylinder by simply ascertaining the diameter, i. e., a vessel 5 inches in diameter the Rule indicates to be 15¾ inches in circumference. The reverse side contains much useful information in large, plain figures regarding the sizes of sixty different articles, such as cans, measures, pails, etc., with straight or flaring sides, flat or pitched top, liquid and dry measure in quarts, gallons and bushels. First is given the dimensions for vessels holding 1 to 5 gallons liquid measure; second, ¼ to 2 bushels dry measure; third, pans with pitched tops 1 to 10 gallons; fourth, cans with flat top 1 to 200 gallons; fifth, vessel holding 1 to 8 quarts, and ½ bushel to 3 bushels dry measure.

	3-Feet	3-Feet
Number	101 Polished	107 Nickel

	4-Feet	4-Feet
Number	0101 Polished	0107 Nickel

WIZARD HAND PUNCH



Forged Steel

Capacity — ¼ inch Hole in No. 18 Ga. Iron and Lighter.

Note:—Furnished regularly with Three Punches and Dies, viz.: ⅛, 3/16 and ¼ inch. Punches and Dies, 5/32, 7/32 and 17/64 inches can be furnished in preference to the regular sizes or extra, as may be specified.

Unless mentioned otherwise, ⅛, 3/16 and ¼ inch Punches and Dies will be sent.

A powerful and easy working Hand Punch for meeting the exacting demands of the mechanic in the shop and for out-of-shop-work.

Guaranteed to withstand the general hard usage which a Hand Punch usually undergoes. An actual test will prove the advantage gained by the use of this little tool.

Number		789C
Length over all	ins.	8¼
Depth Throat	ins.	1½
Weight, each	lbs.	3

Packed one in a box.

STEEL STRAIGHT EDGE

These Straight Edges are made of steel and have beveled edges. They are invaluable around the shop for laying out work in general.

Number		994	995
Length	inches	48	96
Size	inches	2½x5/16	2½x5/16
Shipping Weight	lbs.	7½	15

TINNERS' HAND SNIPS

LAID BLADE — FORGED STEEL

FOR CUTTING STAINLESS METALS

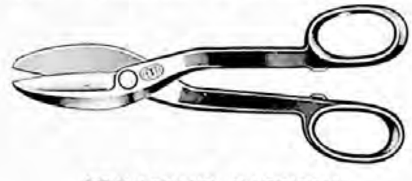
These Snips are branded as above — look for this brand.

Blades are laid with a special alloy tool steel. Will hold a keen, sharp, cutting edge many times longer than ordinary snips before grinding is necessary. Designed to cut with ease — well balanced — bows are large and comfortable to the hand. Will make a full cut at minimum pounds pressure. Blades are highly polished.

Every process in the manufacture of these snips has been given careful attention. Snips that will cut with ease the sheet metals now in every day use offered now for the first time will command popular favor and be appreciated by anyone, as modern times are continually demanding harder and tougher metals. The ideal snip for industrial plants, sheet metal workers and other mechanics.

All snips made regularly with left hand cut for right hand man.

Note — Capacities as listed are from actual test and based on the strength of an average mechanic's hand.



STRAIGHT PATTERN

Finish—Blued Handles and Polished Heads

Nos.	**06**	**6**	**7**
Will cut stainless steel No.	20	21	22
Will cut mild steel No.	18	19	19
Length of cut, inches	4½	4½	4
Length over all, inches	17	15¾	14½
Weight lbs., each	5	3⅝	3

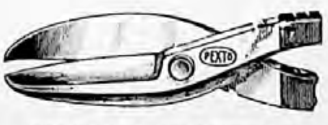
Nos.	**8**	**9**	**10**
Will cut stainless steel No.	22	24	24
Will cut mild steel No.	19	20	20
Length of cut, inches	3½	3	2½
Length over all, inches	13½	12½	11½
Weight, lbs. each	2½	1¾	1½

Nos.	**11***	**12***	**13***
Will cut stainless steel No.	......	......	......
Will cut mild steel No.	28	28	28
Length of cut, inches	2¼	2	1¾
Length over all, inches	10½	8½	8
Weight lbs., each	1	⅝	½

**These numbers are not steel laid.*

Packed one in a box.

For a left handed man we can furnish when specified Nos. **7, 8, 9** with right hand cut.

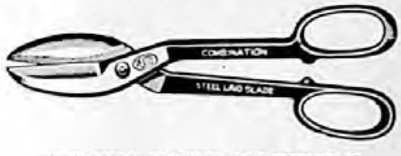


CIRCULAR PATTERN

This snip is exactly the same snip as above except that it has the curved blade.

Nos.	**C7**	**C8**	**C9**	**C10**
Length of cut, inches	4	3½	3	2½

Packed one in a box.



COMBINATION PATTERN

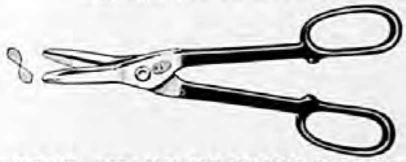
Beveled Blades

Finish—Blued Handles and Polished Heads

Designed to cut circles, scrolls, etc., and are adapted to the same class of work as the regular snip. The jaws are beveled with straight cutting edges which allows the material to pass freely when cutting curves or changing direction of the cut.

Nos.	**17**	**18**	**19**	**20**
Will cut stainless steel No.	22	22	24	24
Will cut mild steel No.	19	19	20	20
Length of cut, inches	4	3½	3	2½
Length over all, inches	14½	13½	12½	11½
Weight lbs., each	3	2¼	2	1½

Packed one in a box.



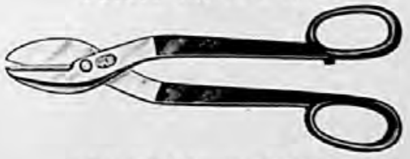
TROJAN, SHARP POINTED PATTERN

Finish—Blued Handles and Polished Heads.

For cutting sheet metal and lighter materials such as pasteboard, mica, linoleum, veneering, etc. They will cut straight or curved lines, and may be used for scroll or cornice work.

No.	**79**
Will cut stainless steel No.	24
Will cut mild steel No.	20
Length of cut, inches	3
Length over all, inches	13
Weight, lbs., each	2¼

Packed one in a box.



"BULLDOG" PATTERN

Finish—Blued Handles and Polished Heads.

A heavy snip designed for cutting the heavier gauges of iron for which the ordinary snip is not adapted. The long handles on this snip offer greater leverage. The jaws are extra heavy.

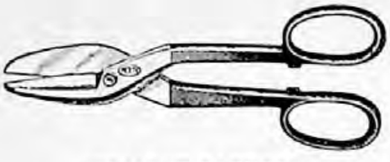
No.	**14**
Will cut stainless steel No.	20
Will cut mild steel No.	17
Length of cut, inches	2½
Length over all, inches	16
Weight lbs., each	4¼

ALSO FURNISHED CIRCULAR PATTERN No. C14

Packed one in a box.

TINNERS' HAND SNIPS

SOLID FORGED STEEL



STRAIGHT PATTERN

Finish—Red Handles and Polished Heads

These Snips were designed to meet the popular demand for a medium priced snip for general use.

Nos.	3½	3	2½	2
Length of cut, ins.	3½	3	2½	2
Length over all, ins.	13¼	12¼	11¼	9¼
Weight, lbs. each	2¼	1¾	1¼	¾

Packed one in a box.

GENERAL PURPOSE POCKET SNIP

Finish—Red Handles and Polished Heads

Adapted to use by the mechanic, plumber, electrician, automobilist, tinsmith and sheet metal worker.

No.	82
Length of cut, inches	2
Length over all, inches	7
Weight, lbs. per dozen	6

Packed six in a box.

TROJAN PATTERN

Finish—Red Handles and Polished Heads

Nos.	81	83
Length of cut, inches	3	1¾
Length over all, inches	12¾	7
Weight, lbs. each	1⅝	⅝

Packed one in a box.

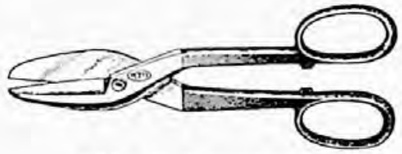
COMBINATION PATTERN

Finish—Red Handles and Polished Heads

These Snips have beveled blades and are adapted for cutting irregular shapes as circles, scrolls, etc. as well as for straight work.

No.	219
Length of cut, inches	3
Length over all, inches	12½
Weight, lbs. each	2

Packed one in a box.



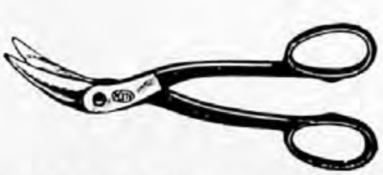
STRAIGHT PATTERN

Finish—Red Handles and Polished Heads

A medium priced Snip for general use.

Nos.	99	100
Length of cut, inches	3	2½
Length over all, inches	12½	10
Weight, lbs. per dozen	22½	15

Packed six in a box.



HAWK'S BILL COMBINATION SCROLL AND CIRCULAR PATTERN

Finish—Blued Handles and Polished Heads

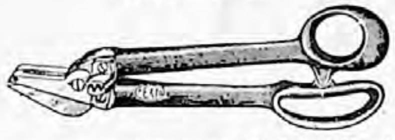
Work can be cut on a straight line, and they will cut circles in very much smaller dimensions than it is possible to cut with any other Snip on the inside as well as on the outside of a sheet of metal.

The blades have a clearance bevel between the cutting edges, which permits the blades to easily turn a sharp corner or work around a small curve. The blades being unusually narrow and ground to an extreme narrowness at the points, they are highly valuable for cutting openings in pipe or cylinders of every description for furnace jackets, thimbles, tee joints, etc.

Nos.	15	23
Will cut iron, No.	28	20
Length of cut, inches	2½	2½
Length over all, inches	11½	13
Weight, lbs. each	1¼	1¾

Packed one in a box.

DOUBLE CUTTING SHEARS



Finish—Black Handles and Polished Heads

The Handles are Malleable Iron and the Blade is Forged Steel with hardened Cutting edge. Great care is exercised in assembling for permitting a joint of pipe to be cut with ease and accuracy, leaving the edges smooth and clean.

Nos.	2A	02A
Length over all, inches	12¾	12¾
Weight, lbs. each	3	3

NOTE—No. 02A are the same as No. 2A except that they do not have the crimping attachment.

Packed one in a box.

BENCH SHEARS

TINNERS' BENCH SHEARS

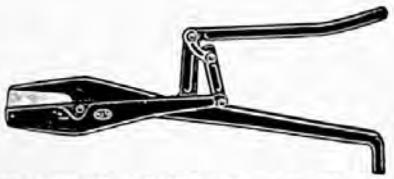
Finish—Black Handles and Polished Heads

As regularly made, bench shears have a right hand cut with the lower blade on the right side of the shear.

Nos.	1	4	6
Capacity Gauge, will cut iron No.	18	20	22
Length of cut, inches	9	7⅜	5¼
Length over all, inches.	39	30	25
Weight, lbs. each	24	12	8¼

Nos.	31	32
Capacity Gauge, will cut iron No.	18	16
Length of cut, inches	4	6
Length over all, inches.	26	39
Weight, lbs. each	9½	26

Packed one in a package.



COMPOUND LEVER BENCH SHEARS

Finish-Black Handles and Polished Blades

A high grade Shear for heavy work. Body is Malleable Iron; Blades high grade Steel properly Hardened and Tempered. Blades are removable, therefore can be replaced.

No.	44
Will cut Iron, Gauge No.	12
Length of cut, inches	4
Length over all, inches	34¼
Weight, lbs. each	21

Packed one in a package.

CONDITIONS OF SALE

Our sales are always for cash. Invoices to parties of established credit may be paid in thirty days from date of invoice.

Shipments are made f. o. b. factory Southington, Conn. All cost incidental to delivery and erection of machinery in purchaser's plant shall be borne by purchaser.

An extra charge is always made for boxing heavy machines for export shipment, or for special packing other than specified in our catalog.

All orders and contracts are subject to approval and acceptance of the home office.

Orders entered on our books cannot be countermanded except with our consent and upon terms that will indemnify us against any loss.

Goods are shipped at purchaser's risk. We are not responsible for delays of carriers, damage to goods in transit or any loss after shipment has been received and receipted for by carrier as in good order whether the goods are shipped f. o. b. cars factory or freight allowed to destination.

Stenographical and clerical errors subject to correction.

Prices are subject to change without notice. Unless otherwise stated quotations are for immediate acceptance.

All agreements are made contingent upon strikes, fires, accidents, delays of any nature or other causes unavoidable or beyond our control.

Unless error has been made by us in manufacturing or shipping an order, we cannot accept the return of goods until definite terms for such return have been mutually agreed upon. We will not accept responsibility for shortages which are not reported within ten days after receipt of shipment.

All articles made by us are inspected and tested up to their full capacity before shipment. Claims made due to defective materials or poor workmanship must be reported for our decision promptly.

Samples of work special equipment will turn out as submitted by us and when accepted and approved by the customer it is agreed that we have completed our contract. Such samples suggesting a change in the equipment for improving the product or when changes are ordered to better conform with general shop practice an additional charge is to be made.

Samples of special material for testing purposes, other than ordinary soft steel shall be furnished by purchaser without charge.

To confer with the local machinist inviting shop expense without our knowledge relieves us of all responsibility and invoices presented to us covering charges for changes made to our equipment under these conditions will not be allowed.

Charges made for patterns or drawings do not convey the right to remove them from our possession.

Where date of delivery is given we will endeavor to complete as near the date as possible but we cannot be held responsible for any loss or inconvenience caused by overdue or non-delivery. Orders accepted for immediate shipment are subject to prior sale.

THE PECK, STOW & WILCOX CO.

OUR OTHER PEXTO PRODUCTS

- POWER SQUARING SHEARS
- POWER PUNCH PRESSES
- POWER DRUM MAKING MACHINERY
- AUTO BODY AND FENDER REPAIR TOOLS
- MECHANICS HAND TOOLS
- SCALE BEAMS AND STEELYARDS
- ROLLER SKATES AND GENERAL HARDWARE

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